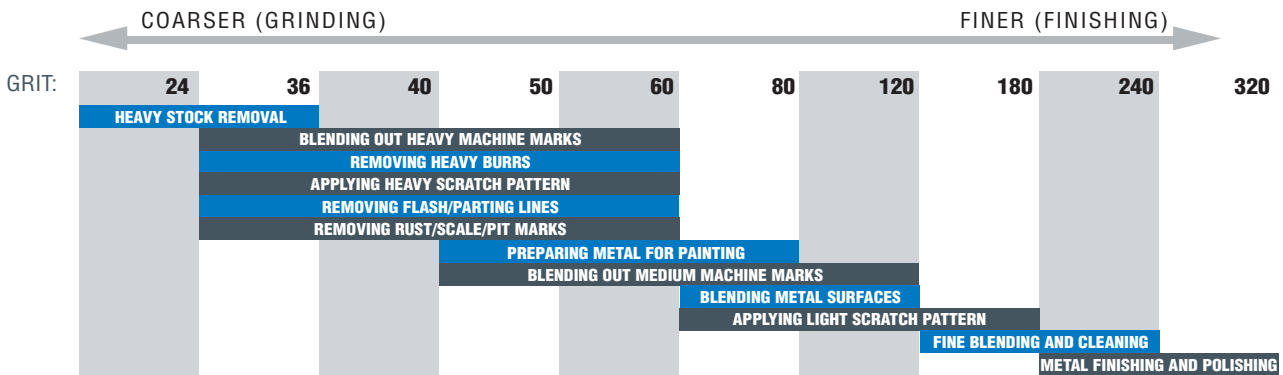


CATEGORY DEFINITION


Best product for blending and polishing contours when smooth running is a primary concern. Used for finishing hard-to-reach areas, removing parting lines, imperfections, and burrs on all surfaces.

- BENEFITS:**
- Spiral construction avoids shadow marks and provides smooth, chatter-free cutting action
 - Achieves close tolerances when finishing curved, contoured, and hard-to-reach areas
 - Fast cutting and removes toughest metal
 - Bands are easily removed and replaced
- GRIT RANGE:** 24 - 320
- ABRASIVE GRAIN:** Aluminum Oxide
- OTHER:** Use with rubber expanding drum

APPLICATION/GRIT RECOMMENDATION GUIDE




AVAILABILITY

GRIT	GOOD							
	Merit							
BRAND:	Aluminum Oxide							
ABRASIVE:	1/4 x 1/2	1/4 x 1	3/8 x 1/2	3/8 x 1	1/2 x 1/2	1/2 x 1	1/2 x 1-1/2	1/2 x 2
24	-	-	-	-	-	08834196712	-	-
36	-	-	-	08834197674	08834196619	08834196591	08834196237	08834196758
40	08834196614	-	-	-	08834196234	08834196174	-	08834196825
50	08834196292	08834196785	08834196386	-	08834196228	08834196214	08834197111	08834196548
60	08834196342	08834196886	08834196829	08834196999	08834196068	08834196212	08834196053	08834196549
80	08834196269	08834196733	08834196512	08834196645	08834196179	08834196215	08834196646	08834196669
100	08834196511	08834196734	08834196513	-	08834196189	08834196534	08834196540	08834196735
120	08834196217	08834197004	08834196747	08834196218	08834196069	08834196210	08834196324	08834196736
150	08834196327	-	-	-	08834196211	08834196772	-	-
180	08834196490	-	08834196504	-	08834196209	08834196713	-	-
240	-	-	08834196481	-	08834196564	08834196814	-	-
320	08834196865	-	08834196830	-	08834196505	08834196487	-	-
PKG. QTY. STOCK	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
MOQ NON-STOCK	400	400	300	300	300	300	300	200
Expanding Rubber Drums								
	1/8 Shank	NA	1/8 Shank	1/8 Shank	1/4 Shank	1/4 Shank	1/4 Shank	1/4 Shank
	30,000 RPM		30,000 RPM	18,000 RPM	30,000 RPM	15,000 RPM	12,000 RPM	10,000 RPM
	08834196030		08834196944	08834196011	08834196904	08834196906	08834196907	08834196908


SOME MERIT SPECIALTY PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.




AVAILABILITY

GOOD								
Merit								
Aluminum Oxide								
GRIT	3/4 x 1/2	3/4 x 3/4	3/4 x 1	3/4 x 1-1/2	3/4 x 2	1 x 1/2	1 x 1	1 x 1-1/2
24	-	08834196613	08834196776	08834196596	-	-	08834196563	08834196708
36	08834196769	08834196609	08834196261	08834196238	08834196953	08834196058	08834196072	08834196525
40	08834196605	08834196236	08834196517	08834196227	08834196826	-	08834196073	08834196546
50	08834196608	08834196183	08834196515	08834196500	08834196757	-	08834196184	08834196078
60	08834196578	08834196168	08834196070	08834196554	08834196745	08834196580	08834196075	08834196060
80	08834196255	08834196161	08834196071	08834196249	08834196756	08834196647	08834196074	08834196162
100	08834196567	08834196230	08834196502	08834196501	08834196766	08834196157	08834196167	08834196257
120	08834196579	08834196226	08834196219	08834196057	08834196746	08834197592	08834196177	08834196677
150	08834196631	08834196231	08834196822	-	08834197283	-	08834196686	08834197639
180	08834197116	08834196056	08834196565	08834196851	-	-	08834196059	08834196790
240	08834196603	08834196859	08834196668	-	66254410751	08834197287	08834196178	08834196526
320	08834196806	-	08834196624	08834199664	-	-	08834196789	08834197700
PKG. QTY. STOCK	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
MOQ NON-STOCK	300	300	300	300	200	200	300	200
Expanding Rubber Drums								
	1/4 Shank 27,000 RPM	1/4 Shank 24,000 RPM	1/4 Shank 17,000 RPM	1/4 Shank 10,000 RPM	1/4 Shank 10,000 RPM	1/4 Shank 20,000 RPM	1/4 Shank 18,000 RPM	1/4 Shank 10,000 RPM
	08834196909	08834196910	08834196911	08834196912	08834196913	08834196914	08834196916	08834196917

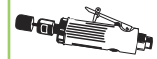
SOME MERIT SPECIALTY PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

GOOD								
Merit								
Aluminum Oxide								
GRIT	1 x 2	1 x 3	1-1/2 x 1	1-1/2 x 1-1/2	1-1/2 x 2	1-1/2 x 3	2 x 1	2 x 1-1/2
24	08834196709	08834197806	08834196684	08834196220	08834196539	-	08834196841	08834196700
36	08834196267	08834196665	08834196222	08834196164	08834196657	08834197063	08834196233	08834196509
40	08834196689	-	08834196223	08834196171	08834196598	-	08834196109	08834196514
50	08834196588	08834197688	08834196185	08834196176	08834196252	-	08834196186	08834196527
60	08834196506	08834196676	08834196503	08834196091	08834196067	08834196703	08834196232	08834196978
80	08834196268	08834196195	08834196254	08834196165	08834196533	08834196809	08834196166	08834196259
100	08834196750	08834196445	08834196216	08834196182	08834196543	08834196522	08834196508	08834196521
120	08834196507	08834196197	08834196707	08834196066	08834196079	08834196343	08834196595	08834196586
150	08834197664	-	08834196989	08834197750	08834197376	-	-	-
180	08834196987	08834196356	-	08834196535	-	08834197869	08834196661	08834196536
240	-	-	08834196491	08834196260	08834197709	-	08834197983	-
320	-	-	08834196063	08834197647	-	-	-	-
PKG. QTY. STOCK	100/box	100/box	100/box	100/box	100/box	100/box	100/box	100/box
MOQ NON-STOCK	200	100	300	200	200	100	200	200
Expanding Rubber Drums								
	1/4 Shank 8,000 RPM	NA	1/4 Shank 12,000 RPM	1/4 Shank 10,000 RPM	1/4 Shank 8,000 RPM	NA	1/4 Shank 11,000 RPM	1/4 Shank 8,000 RPM
	08834196918		08834196921	08834196922	08834196923		08834196926	08834196927

SOME MERIT SPECIALTY PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

GOOD							
Merit							
Aluminum Oxide							
GRIT	2 x 2	2 x 3	2-1/4 x 3	3 x 1	3 x 1-1/2	3 x 2	3 x 3
24	08834196516	08834197903	-	08834196795	-	08834196263	08834196256
36	08834196110	08834196827	08834197140	08834196717	08834196802	08834196545	08834196262
40	08834196172	08834196151	08834197158	08834196755	-	08834196090	08834196555
50	08834196187	08834196152	08834196620	-	-	08834196264	08834196253
60	08834196173	08834196175	-	08834196150	08834196719	08834196530	08834196188
80	08834196181	08834196198	08834196270	08834196524	08834196633	08834196265	08834196159
100	08834196193	08834196199	-	08834196831	-	-	08834196250
120	08834196585	08834196200	08834196729	08834196089	-	08834196531	08834196572
150	08834196629	-	08834195857	-	-	-	08834196452
180	08834196306	-	-	-	-	-	08834196131
240	08834196375	-	-	-	-	-	08834196574
320	08834196628	-	08834195825	-	-	-	08834197968
PKG. QTY. STOCK	100/box	100/box	100/box	100/box	100/box	100/box	100/box
MOQ NON-STOCK	200	100	100	200	200	100	100
Expanding Rubber Drums							
	1/4 Shank 6,000 RPM	NA	NA	3/8 Shank 3,000 RPM	NA	3/8 Shank 3,000 RPM	3/8 Shank 3,000 RPM
	08834196928			08834196929		08834196930	08834196931

SOME MERIT SPECIALTY PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.



CATEGORY DEFINITION

Cartridge, spiral rolls and cone points are strips of abrasive cloth rolled and glued to form a solid shape that is designed to break down during use and reveal the next layer of abrasive.

APPLICATIONS: Used on inside surfaces and inside corners where other abrasive shapes cannot reach. Typically these are used on high-speed air grinders and are always mounted on a mandrel. Ideal for flash removal, polishing, or removing machine tool marks, and edge breaking.

SHAPES: Cartridge rolls, spiral rolls (full taper, half taper, and sidewall taper), and tapered cone points

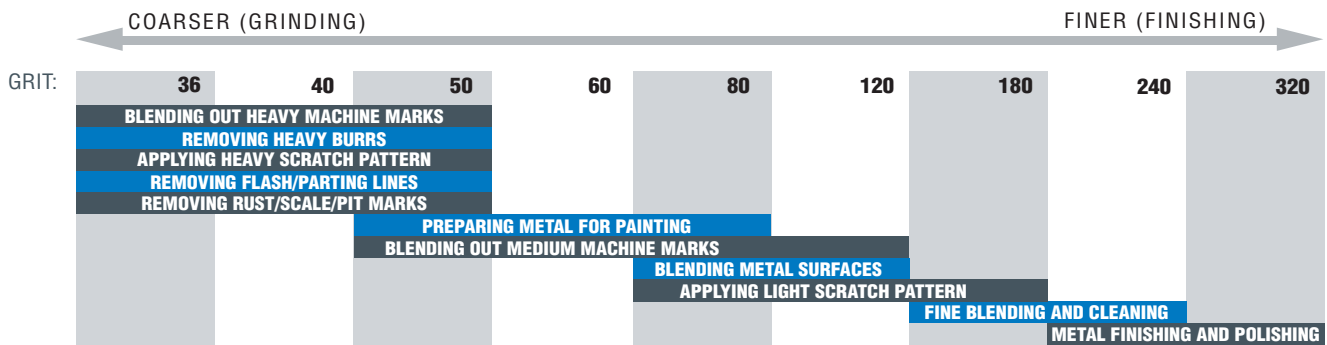
GRIT RANGE: 36 - 320

ABRASIVE GRAIN: Ceramic Alumina, Aluminum Oxide, Silicon Carbide

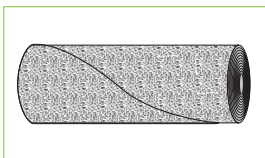
BACKING: Cotton Cloth

MAXIMUM RPM: 1/8" to 1/2" – 23,000
5/8" to 1" – 18,000
1" to 1-1/2" – 15,000

APPLICATION/GRIT RECOMMENDATION GUIDE



Cartridge Rolls



- Effective for flash removal
- Polishing or removing machine tool marks
- Edge breaking
- Valuable abrasive tool for reaching into corners, where larger diameter tools cannot work
- All cartridge roll part numbers shown are resin bond, half-glued
- Quarter and full glue are also available for quotation as made-to-order products

Refer to the back of this section for mandrels.



FEATURED PRODUCTS



MERIT CERAMIC ALUMINA CARTRIDGE ROLLS

BEST CHOICE FOR HARD-TO-GRIND MATERIALS – STAINLESS STEEL, COBALT, INCONEL, AND TITANIUM

FEATURES

- Next-generation ceramic alumina abrasive grain
- Advanced grinding aid
- Improved resin bond system
- Strong X-weight cotton backing

BENEFITS

- Greatest productivity with significantly faster cut rates
- Resists wear, resulting in 50% – 300% longer life
- Cooler cutting, longer life
- Exceptional grain retention and longer life
- Durability and even wear

AVAILABILITY

TIER:	BEST
BRAND:	Merit
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/4 x 1-1/2 x 1/8	60	100	66261194384
Use M-9 Mandrel	80	100	66261194394
	120	100	66261194397
3/8 x 1-1/2 x 1/8	60	100	66261194392
Use M-9 Mandrel	80	100	66261194395
	120	100	66261194398

CONTINUED

AVAILABILITY

TIER:	BEST
BRAND:	Merit
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	66261194393
Use M-9 Mandrel	80	100	66261194396
	120	100	66261194399



MERIT CERAMIC ALUMINA BLEND CARTRIDGE ROLLS

BETTER CHOICE FOR STAINLESS STEEL AND OTHER HARD-TO-GRIND MATERIALS

FEATURES

- Sharp ceramic alumina abrasive blend
- Durable X-weight cotton backing
- Grinding aid

BENEFITS

- Delivers cooler cut
- Ensures even wear
- Promotes cooler cut on stainless steel

AVAILABILITY

TIER:	BETTER
BRAND:	Merit
ABRASIVE:	Ceramic Alumina Blend
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/4 x 1-1/2 x 1/8	60	100	66261040477
Use M-9 Mandrel	80	100	69957300001
3/8 x 1-1/2 x 1/8	60	100	66261041270
Use M-9 Mandrel	80	100	08834187134

CONTINUED

AVAILABILITY

TIER:	BETTER
BRAND:	Merit
ABRASIVE:	Ceramic Alumina Blend
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	08834184221
Use M-9 Mandrel	80	100	66261012798



MERIT ALUMINUM OXIDE PLUS CARTRIDGE ROLLS

EFFECTIVE STARTING SPECIFICATION FOR FLASH REMOVAL, POLISHING, OR REMOVING MACHINE TOOL MARKS AND EDGE BREAKING ON ALL TYPES OF METAL

FEATURES

- Premium aluminum oxide abrasive
- Advanced, full resin bond system

BENEFITS

- Controls aggressiveness while cool cutting
- Ensures edge adhesion and long life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Premium Aluminum Oxide
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/4 x 1-1/2 x 1/8	60	100	77696089001
Use M-9 Mandrel	80	100	77696089002
	120	100	77696089003
3/8 x 1-1/2 x 1/8	60	100	77696089004
Use M-9 Mandrel	80	100	77696089005
	120	100	77696089006

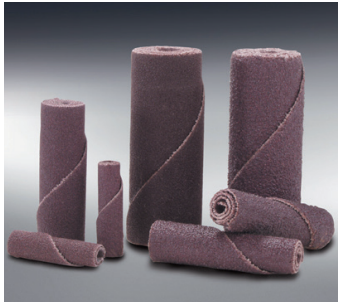
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AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Premium Aluminum Oxide
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	77696089007
Use M-9 Mandrel	80	100	77696089008
	120	100	77696089009

Refer to the back of this section for mandrels.



MERIT ALUMINUM OXIDE CARTRIDGE ROLLS

GOOD STARTING SPECIFICATION FOR FLASH REMOVAL, POLISHING, OR REMOVING MACHINE TOOL MARKS AND EDGE BREAKING ON ALL TYPES OF METAL

FEATURES

- Quality aluminum oxide abrasive
- Strong X-weight cotton backing construction
- Durable resin bond system

BENEFITS

- Tough and durable
- For extended durability and even wear
- Provides longer life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton Cloth

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/16 x 3/4 x 3/32	80	100	08834180005
3/16 x 1 x 3/32	60	100	08834180023
Use M-2E Mandrel	80	100	08834180024
	100	100	08834180025
	120	100	08834180026
	150	100	08834180027
	180	100	08834180028
	240	100	08834180030
	320	100	08834180032
1/4 x 3/4 x 1/8	60	100	08834180042
Use M-3 or M-7 Mandrel	80	100	08834180043
	120	100	08834180045
1/4 x 1 x 1/8	50	100	08834180060
Use M-4 or M-8 Mandrel	60	100	08834180061
	80	100	08834180062
	100	100	08834180063
	120	100	08834180064
	150	100	08834180065
	180	100	08834180066
	240	100	08834180068
	320	100	08834180070
1/4 x 1-1/2 x 1/8	50	100	08834180079
Use M-9 Mandrel	60	100	08834180080
	80	100	08834180081
	100	100	08834180082
	120	100	08834180083
	150	100	08834180084
	180	100	08834180085
	320	100	08834180089
1/4 x 2 x 1/8	80	100	08834180100
Use M-10 Mandrel	100	100	08834180101
	120	100	08834180102
5/16 x 1 x 1/8	60	100	08834180137
use M-4 or M-8 Mandrel	80	100	08834180138
	120	100	08834180140
5/16 x 1-1/2 x 1/8	60	100	08834180156
use M-9 Mandrel	80	100	08834180157
	120	100	08834180159
3/8 x 3/4 x 1/8	60	100	08834180194
use M-7 Mandrel	80	100	08834180195
	120	100	08834180197
3/8 x 1 x 1/8	40	100	08834180211
use M-8 Mandrel	50	100	08834180212
	60	100	08834180213
	80	100	08834180214
	100	100	08834180215
	120	100	08834180216
	150	100	08834180217
	180	100	08834180218
	240	100	08834180220

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

CONTINUED

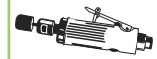
AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 1-1/2 x 1/8	36	100	08834180228
use M-9 Mandrel	40	100	08834180229
	50	100	08834180230
	60	100	08834180231
	80	100	08834180232
	100	100	08834180233
	120	100	08834180234
	150	100	08834180235
	180	100	08834180236
	240	100	08834180238
	320	100	08834180240
3/8 x 2 x 1/8	60	100	08834180250
use M-10 Mandrel	80	100	08834180251
	100	100	08834180252
	120	100	08834180253
1/2 x 3/4 x 1/8	80	100	08834180270
use M-7 Mandrel			
1/2 x 1 x 1/8	40	100	08834180286
use M-8 Mandrel	50	100	08834180287
	60	100	08834180288
	80	100	08834180289
	100	100	08834180290
	120	100	08834180291
	150	100	08834180292
	180	100	08834180293
	240	100	08834180295
	320	100	08834180297
1/2 x 1-1/2 x 1/8	36	100	08834180304
use M-9 Mandrel	40	100	08834180305
	50	100	08834180306
	60	100	08834180307
	80	100	08834180308
	100	100	08834180309
	120	100	08834180310
	150	100	08834180311
	180	100	08834180312
	240	100	08834180314
	320	100	08834180316
1/2 x 1-1/2 x 3/16	120	100	08834180919
use M-16 Mandrel			
1/2 x 2 x 1/8	60	100	08834180326
use M-10 Mandrel	80	100	08834180327
	100	100	08834180328
	120	100	08834180329
	180	100	08834180331
	240	100	08834180333
	320	100	08834180335
1/2 x 2 x 3/16	60	100	08834180350
use M-17 Mandrel	80	100	08834180653
	120	100	08834180338
1/2 x 2 x 1/4	40	100	08834183168
use M-22 Mandrel	80	100	08834180351
5/8 x 1 x 3/16	80	100	08834180364
use M-15 Mandrel			

CONTINUED

Refer to the back of this section for mandrels.



AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
5/8 x 1-1/2 x 1/8	36	100	08834180395
use M-9 Mandrel	40	100	08834180392
	50	100	08834180393
	60	100	08834180275
	80	100	08834180789
	120	100	08834180394
5/8 x 1-1/2 x 3/16	50	100	08834180381
use M-16 Mandrel	60	100	08834180382
	80	100	08834180383
5/8 x 2 x 1/8	60	100	08834182505
use M-10 Mandrel	80	100	08834181080
5/8 x 2 x 3/16	50	100	08834180400
use M-10 Mandrel	60	100	08834180401
	80	100	08834180402
	100	100	08834180403
3/4 x 1 x 1/8	80	100	08834180469
use M-8 Mandrel	120	100	08834181543
3/4 x 1 x 3/16	40	100	08834180456
use M-15 Mandrel	80	100	08834180459
	120	100	08834180461
3/4 x 1-1/2 x 1/8	40	100	08834180069
use M-9 Mandrel	60	100	08834180490
	80	100	08834180527
	120	100	08834180487
3/4 x 1-1/2 x 3/16	36	100	08834180474
use M-16 Mandrel	40	100	08834180475
	50	100	08834180476
	60	100	08834180477
	80	100	08834180478
	100	100	08834180479
	120	100	08834180480
	180	100	08834180482

CONTINUED

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/4 x 1-1/2 x 1/4	36	100	08834180907
100/box 400/case	60	100	08834180489
use M-21 Mandrel	80	100	08834180358
	100	100	08834180523
	120	100	08834180488
	150	100	08834182807
3/4 x 2 x 1/8	60	100	08834180791
use M-10 Mandrel			
3/4 x 2 x 3/16	40	100	08834180494
use M-17 Mandrel	60	100	08834180496
	80	100	08834180497
	100	100	08834180498
	120	100	08834180499
3/4 x 2 x 1/4	60	100	08834180506
use M-22 Mandrel	80	100	08834181297
	100	100	08834180509
	120	100	08834180507
1 x 1-1/2 x 1/8	60	100	08834180580
use M-9 Mandrel	80	100	08834180584
1 x 1-1/2 x 1/4	36	100	08834181195
use M-21 Mandrel	60	100	08834180587
	80	100	08834180583
1 x 2 x 3/16	40	100	08834180589
use M-17 Mandrel	60	100	08834180591
	80	100	08834180592
1 x 2 x 1/4	60	100	08834180603
use M-22 Mandrel	80	100	08834180606
	120	100	08834180585

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.



MERIT SILICON CARBIDE CARTRIDGE ROLLS

GOOD CHOICE FOR TOUGH, DIFFICULT-TO-GRIND MATERIALS, AS WELL AS SOFT, LOADING MATERIALS

FEATURES

- Sharp silicon carbide abrasive
- Durable resin bond system

BENEFITS

- Provides high initial cut on non-ferrous and soft-loading materials such as titanium, masonry, composites, plastic, and rubber
- Exceptional grain retention and longer life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/4 x 1-1/2 x 1/8	60	100	08834183274
Use M-9 Mandrel	80	100	08834182359
	120	100	08834189131
3/8 x 1-1/2 x 1/8	60	100	08834181309
Use M-9 Mandrel	80	100	08834180710
	120	100	66261042229

CONTINUED

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

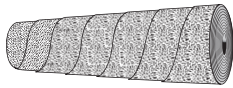
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	08834189233
Use M-9 Mandrel	80	100	08834180712
	120	100	66261086969

Refer to the back of this section for mandrels.



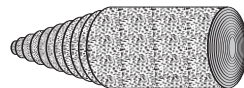
Spiral Rolls

- All spiral roll part numbers shown are full tapered, resin bond, half glued
- Half-tapered and sidewall-tapered are available for quotation as made-to-order products
- Quarter and full glue are also available for quotation as made-to-order products
- Ceramic Alumina blend spiral rolls are also available for quotation as made-to-order products



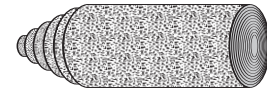
Full Taper

- Especially useful for grinding/polishing of channels, fillets and radii, and deburring small holes
- Full taper used when the area to finished is hard to reach with a full cartridge roll
- The tapered roll conforms to smaller areas
- Fits into irregular concaves, contours, channels



Half Taper

- Used when the area to be finished is not narrow but a beginning point on the roll is needed
- The portion of the roll that is not tapered is then used to finish off the sides



Sidewall Taper

- The portion of the roll that is tapered guides the roll down to the area to be finished
- The sidewall then finishes off the sides

FEATURED PRODUCTS



MERIT CERAMIC ALUMINA SPIRAL ROLLS – FULL TAPER

BEST CHOICE FOR HARD-TO-GRIND MATERIALS – STAINLESS STEEL, COBALT, INCONEL, AND TITANIUM

FEATURES

- Next-generation ceramic alumina abrasive grain
- Advanced grinding aid
- Improved resin bond system
- Strong X-weight cotton backing

BENEFITS

- Greatest productivity with significantly faster cut rates
- Resists wear, resulting in 50% – 300% longer life
- Cooler cutting, longer life
- Exceptional grain retention and longer life
- Durability and even wear

AVAILABILITY

TIER:	BEST
BRAND:	Merit
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 1-1/2 x 1/8	60	100	66261194481
Use M-9 Mandrel	80	100	66261194490
	120	100	66261194491

CONTINUED

AVAILABILITY

TIER:	BEST
BRAND:	Merit
ABRASIVE:	Ceramic Alumina
BACKING:	Cotton
OTHER:	Supersized

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	66261194484
Use M-9 Mandrel	80	100	66261194492
	120	100	66261194495



MERIT ALUMINUM OXIDE PLUS SPIRAL ROLLS – FULL TAPER

ESPECIALLY USEFUL FOR COOLER GRINDING/POLISHING OF CHANNELS, FILLETS AND RADII, AND DEBURRING SMALL HOLES..

FEATURES

- Premium aluminum oxide abrasive
- Strong X-weight cotton backing construction
- Advanced, full resin bond system

BENEFITS

- Runs cooler and more efficiently; ideal for grinding exotic alloys
- For extended durability and even wear
- Provides exceptional grain retention and longer life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Premium Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 1-1/2 x 1/8	60	100	77696089010
use M-9 Mandrel	80	100	77696089011
	120	100	77696089012

CONTINUED

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Premium Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	77696089013
use M-9 Mandrel	80	100	77696089014
	120	100	77696089015

Refer to the back of this section for mandrels.



MERIT ALUMINUM OXIDE SPIRAL ROLLS – FULL TAPER

ESPECIALLY USEFUL FOR COOLER GRINDING/POLISHING OF CHANNELS, FILLETS AND RADII, AND DEBURRING SMALL HOLES..

FEATURES

- Quality aluminum oxide abrasive
- Strong X-weight cotton backing construction
- Durable resin bond system

BENEFITS

- For the buyer whose major purchasing criterion is low initial price
- Durability and even wear
- Exceptional grain adhesion and longer life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 1 x 1/8	60	100	08834181714
use M-8 Mandrel	80	100	08834181715
	120	100	08834181717
	180	100	08834181719
3/8 x 1-1/2 x 1/8	50	100	08834181723
use M-9 Mandrel	60	100	08834181724
	80	100	08834181708
	120	100	08834181727
	150	100	08834181728
	180	100	08834181709
1/2 x 1 x 1/8	60	100	08834181734
use M-8 Mandrel	80	100	08834181735
	120	100	08834181737
	180	100	08834181739
1/2 x 1-1/2 x 1/8	36	100	08834181230
use M-9 Mandrel	40	100	08834181742
	50	100	08834181743
	60	100	08834181744
	80	100	08834181745
	100	100	08834181746
	120	100	08834181747
	180	100	08834181749
	240	100	08834181750

CONTINUED

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 2 x 1/8	60	100	08834181754
use M-10 Mandrel	80	100	08834181755
	120	100	08834181757
5/8 x 1-1/2 x 1/8	100	100	08834181776
use M-9 Mandrel	120	100	08834181777
	240	100	08834183313
	320	100	08834181781
5/8 x 1-1/2 x 3/16	80	100	08834181444
use M-16 Mandrel			
3/4 x 1-1/2 x 1/8	60	100	08834181286
use M-9 Mandrel	80	100	08834180886
3/4 x 1-1/2 x 3/16	50	100	08834181807
use M-16 Mandrel	60	100	08834181808
	80	100	08834181809
	120	100	08834181811
3/4 x 2 x 3/16	60	100	08834181820
use M-17 Mandrel			
1 x 1-1/2 x 1/8	60	100	08834181240
use M-9 Mandrel			
1 x 2 x 3/16	36	100	08834181875
use M-17 Mandrel	60	100	08834181878
	80	100	08834181879

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.



MERIT SILICON CARBIDE SPIRAL ROLLS – FULL TAPER

GOOD CHOICE FOR TOUGH, DIFFICULT-TO-GRIND MATERIALS, AS WELL AS SOFT, LOADING MATERIALS

FEATURES

- Sharp silicon carbide abrasive
- Durable resin bond system

BENEFITS

- Provides high initial cut on non-ferrous and soft-loading materials such as titanium, masonry, composites, plastic, and rubber
- Exceptional grain retention and longer life

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/8 x 1-1/2 x 1/8	60	100	08834189901
use M-9 Mandrel	80	100	08834189904
	120	100	66261046936

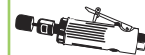
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AVAILABILITY

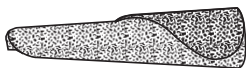
TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Silicon Carbide
BACKING:	Cotton

SIZE (D x L x H)	GRIT	STD. PKG.	PART #
1/2 x 1-1/2 x 1/8	60	100	66261185977
use M-9 Mandrel	80	100	08834183460
	120	100	08834183448

Refer to the back of this section for mandrels.



Tapered Cone Points



- Tapered cone points are similar to cartridge rolls but their shape lends greater accessibility to many difficult-to-reach work areas
- They are used for deburring holes and in close tolerance work areas
- Popular sizes and mandrels are listed, with additional sizes available upon request as made-to-order products
- Ceramic alumina, ceramic alumina blend, aluminum oxide plus, and silicon carbide cone points are available upon request as made-to-order products

FEATURED PRODUCTS



MERIT ALUMINUM OXIDE TAPERED CONE POINTS

GOOD STARTING SPECIFICATION FOR FLASH REMOVAL, POLISHING, OR REMOVING MACHINE TOOL MARKS AND EDGE BREAKING ON ALL TYPES OF METAL IN DIFFICULT-TO-REACH WORK AREAS.

FEATURES

- Quality aluminum oxide abrasive
- Strong X-weight cotton backing construction
- Durable resin bond system

BENEFITS

- Tough and durable
- For extended durability and even wear
- Provides longer life

AVAILABILITY

TIER:	GOOD		
BRAND:	Merit		
ABRASIVE:	Aluminum Oxide		
BACKING:	Cotton		
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
5/16 x 1-1/2 x 5°	80	500	08834180873
Use B-20 Mandrel	100	500	08834182043
	120	500	08834182717
	150	500	08834186890
	180	500	08834182535
	240	500	08834182044
	320	500	08834182537

CONTINUED

AVAILABILITY

TIER:	GOOD		
BRAND:	Merit		
ABRASIVE:	Aluminum Oxide		
BACKING:	Cotton		
SIZE (D x L x H)	GRIT	STD. PKG.	PART #
3/16 x 1 x 2-1/2°	50	500	08834186892
Use K-110 Mandrel	60	500	08834186893
	80	500	08834180918
	100	500	08834182197
	120	500	08834182199
	150	500	08834182200
	180	500	08834186894
	240	500	08834186895
	320	500	08834182855

Test Kits



Merit Ceramic Alumina Cartridge Roll Test Kit

- Part # 66261066726
- Kit includes a variety of our Merit ceramic alumina cartridge rolls, spiral rolls and mandrels in popular sizes and grits.

Merit Aluminum Oxide Cartridge Roll Test Kit “CR”

- Part # 08834181061
- Includes over 120 pieces of our most popular sizes, grits and shapes with their appropriate mandrels.

Merit General Purpose Test Kit “GP”

- Part # 08834169025
- Includes samples of various Merit abrasive specialties. One of these kits could be worth the cost of the entire kit by solving your problems in deburring, polishing and grinding.

Merit Porting Test Kit “APK-MO”

- Part # 08834169032
- The samples in this kit highlight Merit specialties for general metal and wood working polishing and finishing applications.



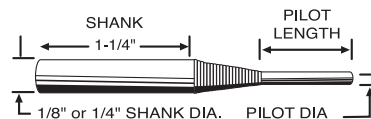
Cartridge and Spiral Roll Mandrels

MODEL #	PILOT DIA.	PILOT LENGTH	SHANK DIA.	SHANK LENGTH	OVERALL LENGTH	PART #
Cartridge and Spiral Roll Mandrels						
M-2E	3/32	3/4	1/4	1	3	08834183799
M-2	3/32	1	1/8	1	3	08834181202
M-3	1/8	1/2	1/8	1	2-1/2	08834181203
M-4	1/8	3/4	1/8	1	2-1/2	08834181204
M-5	1/8	1	1/8	1	2-3/4	08834181205
M-6	1/8	1-1/2	1/8	1	2-1/2	08834181206
M-7	1/8	1/2	1/4	1-1/4	2-1/4	08834181207
M-8	1/8	3/4	1/4	1-1/4	2-1/2	08834181208
M-9	1/8	1	1/4	1-1/4	2-3/4	08834181209
M-10	1/8	1-1/2	1/4	1-1/4	3-1/4	08834181210
M-11	1/8	2	1/4	1-1/4	4	08834181211
M-12	3/16	1/2	1/8	1-1/4	2-1/4	08834181212
M-13	3/16	3/4	1/8	1-1/4	2-1/2	08834181213
M-14	3/16	1/2	1/4	1-1/4	2-1/2	08834181214
M-15	3/16	3/4	1/4	1-1/4	2-3/4	08834181215
M-16	3/16	1	1/4	1-1/4	3	08834181216
M-17	3/16	1-1/2	1/4	1-1/4	3-1/2	08834181217
M-18	3/16	2	1/4	1-1/4	4	08834181218
M-19	1/4	1/2	1/4	1-1/4	2-1/2	08834181219
M-20	1/4	3/4	1/4	1-1/4	2-3/4	08834181220
M-21	1/4	1	1/4	1-1/4	3	08834181221
M-22	1/4	1-1/2	1/4	1-1/4	3-1/2	08834181222
M-23	1/4	2	1/4	1-1/4	4	08834181223
M-24	5/16	3/4	1/4	1-1/4	2-3/4	08834181224
M-25	5/16	1	1/4	1-1/4	3	08834181225
M-26	5/16	1-1/2	1/4	1-1/4	3-1/2	08834181226
M-27	5/16	2	1/4	1-1/4	4	08834181227

STANDARD PACKAGE = 1

Recommended Pilot Length for Mandrels

3/4 Roll Length	use 1/2 Pilot
1 Roll Length	use 3/4 Pilot
1-1/2 Roll Length	use 1 Pilot
2 Roll Length	use 1-1/2 Pilot



Extra Shank Length Mandrels

MODEL #	SHANK LENGTH	OVERALL LENGTH	PART NO.
Extras Shank Length Mandrels			
M-8-4	4	5-1/4	08834180116
M-8-6	6	7-1/4	08834180122
M-9-2.5	2-1/2	4	08834180096
M-9-3	3	4-1/2	08834180129
M-9-4	4	5-1/2	08834180074
M-9-6	6	7-1/2	08834180131
M-9-8	8	9-1/2	08834180133
M-10-4	1-3/4	4	08834180092
M-10-6	3-3/4	6	08834180145

ALL EXTRA SHANK LENGTH MANDRELS ARE 1/4" DIAMETER

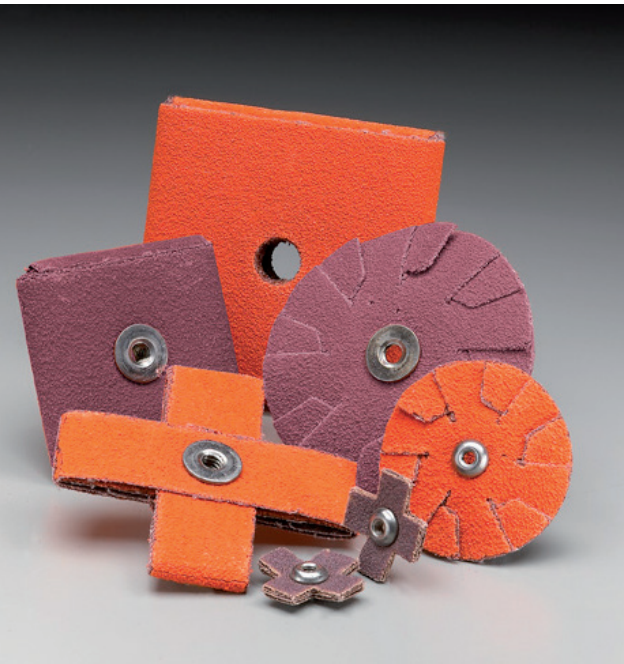
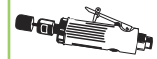
STANDARD PACKAGE = 1

Tapered Cone Point Mandrels

DESCRIPTION	SHANK	PART #
Cone Point Mandrels		
A-10	1/4	08834181300
B-20	1/4	08834181301
C-30	1/4	08834181302
D-40	1/4	08834181303
E-50	A1/4	08834181304
F-60	1/4	08834181305
G-70	1/4	08834181306
H-80	1/4	08834181307
I-90	1/4	08834181308
K-110	1/8	08834181310

STANDARD PACKAGE = 1



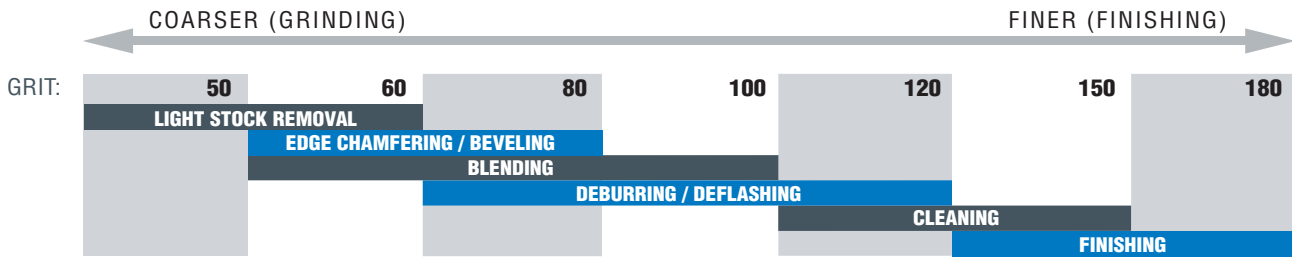


CATEGORY DEFINITION

Square pads, cross pads and overlap slotted discs are all used on high-speed pneumatic tools for deburring, blending, cleaning, and polishing applications. All of these abrasive specialties are designed for applications in small, tight, hard-to-access locations on parts that are being finished.

- BENEFITS:** Variety of shapes and sizes to fit application and part geometry
 Shapes provide flexibility for the application, while eliminating aggressiveness of the sanding action
 Cross pads allow visibility of the surface while sanding, to ensure correct amount of material is removed
- GRIT RANGE:** 50 – 180
- ABRASIVE GRAIN:** Ceramic Alumina, Aluminum Oxide
- BACKING:** Cotton
- MAXIMUM RPM:** 1" Diameter – 25,000
 1-1/2" to 2" Diameter – 18,000 to 23,000
 2-1/2" Diameter – 14,000 to 18,000
 3" Diameter – 12,000 to 14,000
 4" Diameter – 8,000 to 12,000
 5" to 6" Diameter – 5,500 to 7,500

APPLICATION/GRIT RECOMMENDATION GUIDE



FEATURED PRODUCTS



MERIT CERAMIC ALUMINA

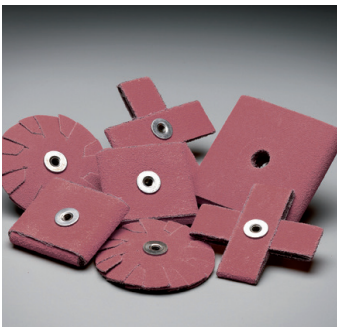
BEST FOR HARD-TO-GROUND MATERIALS – STAINLESS STEEL, COBALT, INCONEL, AND TITANIUM

FEATURES

- Next-generation ceramic alumina abrasive grain
- Advanced grinding aid
- Improved resin bond system

BENEFITS

- Significantly faster cut rates versus any other abrasive
- Resists wear, resulting in 50%-300% longer life
- Greatest productivity; lowest total cost
- Cooler cutting, longer life
- Improved grain retention and longer life



MERIT ALUMINUM OXIDE

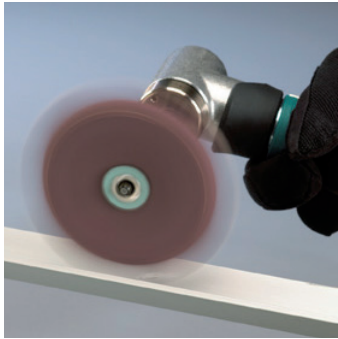
GOOD FOR MOST ID DEBURRING AND POLISHING APPLICATIONS

FEATURES

- Quality aluminum oxide abrasive grain
- Resin bond system
- Standard quick-change eyelet for easy mounting and removal on quick-change mandrel

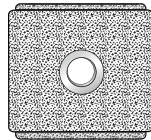
BENEFITS

- Versatile; ideal for deburring, chamfering, and polishing most radii, holes, recesses, and cylinder walls
- Good grain retention and life
- Minimal downtime
- Mandrel use increases range and versatility



Square Pads

AVAILABILITY



BEST

TIER: Merit
BRAND: Ceramic Alumina
ABRASIVE: Supersized
OTHER:



GOOD

Merit
Aluminum Oxide

SIZE (L x W x T)	EYELET	GRIT	STD. PKG.	PART #	PART #
1 x 1 x 6 ply	8-32	80	100		08834184826
1 x 1 x 8 ply	8-32	60	100		08834184828
		80	100		08834184124
		120	100		08834184994
1-1/2 x 1-1/2 x 1/2	1/4-20	60	100		08834184463
		80	100		08834184125
2 x 2 x 1/2	1/4-20	60	100	66261194520	08834184334
		80	100	66261194552	08834184397
		120	100	66261194554	
2 x 2 x 3/4	1/4-20	50	100		08834184487
		80	100		08834184394
3 x 3 x 1/4	1/4-20	60	100	66261194531	
		80	100	66261194555	08834184882
		120	100	66261194556	
3 x 3 x 1/2	1/4-20	50	100		08834182152
		60	100	66261194528	08834182057
		80	100	66261194557	08834184336
		120	100	66261194558	

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS. CERAMIC ALUMINA BLEND AND ALUMINUM OXIDE PLUS SQUARE PADS ARE ALSO AVAILABLE UPON REQUEST AS MADE-TO-ORDER PRODUCTS.

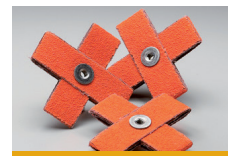
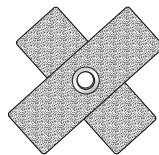
Merit Square Pads

- Corners wear down consistently exposing fresh abrasive; the pad becomes round for less aggressive stock removal
- Grind almost as fast as hard wheels, but are much smoother and easier to control
- For quick blending of channels, fillets, corners, or spotting flat surfaces



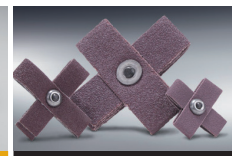
Cross Pads

AVAILABILITY



BEST

TIER: Merit
BRAND: Ceramic Alumina
ABRASIVE: Supersized
OTHER:



GOOD

Merit
Aluminum Oxide

SIZE (L x W x T)	PLY	EYELET	GRIT	STD. PKG.	PART #	PART #
3/4 x 3/4 x 3/8	8	3-48	80	100		08834185578
1 x 1 x 3/8	8	3-48	60	100		08834184943
			80	100		08834185519
			100	100		08834184195
			120	100		08834185164
1-1/2 x 1-1/2 x 1/2	8	8-32	60	100	66261194496	08834184258
			80	100	66261194508	08834184465
			100	100		08834182196
			120	100	66261194511	08834182148
2 x 2 x 1/2	8	8-32	60	100		08834182156
			80	100		08834182157
			120	100		08834182132
2 x 2 x 3/4	8	8-32	60	100	66261194502	08834184128
			80	100	66261194513	08834184194
			120	100	66261194516	08834184285
2 x 2 x 1	8	8-32	120	100		08834184805
2-1/4 x 2-1/4 x 1/2	8	8-32	80	100		08834184402
2-1/2 x 2-1/2 x 3/4	8	8-32	80	100		08834184206
			120	100		08834184074
3 x 3 x 1	8	1/4-20	60	100	66261194504	08834182135
			80	100	66261194549	08834184119
			120	100	66261194551	08834184116
3 x 3 x 1	10	1/4-20	80	100		08834182140
3 x 3 x 1-1/2	10	1/4-20	80	100		08834182184
4 x 4 x 1	8	1/4-20	60	100		08834184142
			80	100		08834184135
			120	100		08834184377
4 x 4 x 1-1/2	8	1/4-20	80	100		08834184129
			120	100		08834184370

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS. CERAMIC ALUMINA BLEND AND ALUMINUM OXIDE PLUS CROSS PADS ARE ALSO AVAILABLE UPON REQUEST AS MADE-TO-ORDER PRODUCTS.

Merit Cross Pads

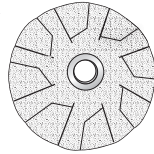
- The shape of Merit cross pads enables you to see through to the contact area, and provides greater flexibility than square pads to conform to variable internal diameters
- Used for close-tolerance polishing of small radii and channels, deburring, and finishing of bell-mouth configurations
- All pads are furnished with standard quick-change eyelet, as listed
- Plain hole sizes must be specified and are available for quotation as made-to-order products

Refer to the back of this section for mandrels.



Overlap Slotted Discs

AVAILABILITY



TIER:

BEST

GOOD

GOOD

BRAND:

Merit

Merit

Merit

ABRASIVE:

Ceramic Alumina

Aluminum Oxide

Aluminum Oxide

OTHER:

Supersized, 2-Ply

2 Per Set

4 Per Set

DIA.	EYELET	GRIT	STD. PKG.	PART #	PART #	PART #	
1	8-32	60	100		08834184346		
		80	100		08834184019		08834184085
		100	100		08834184224		
		120	100		08834184151		08834184236
		180	100		08834185078		
1-1/4	8-32	60	100		08834184270		
		80	100		08834184065		
		100	100		08834184291		
		120	100		08834184084		
1-1/2	8-32	60	100	66261195051	08834184066		
		80	100	66261195368	08834184079		
		100	100		08834184279		08834184023
		120	100	66261195367	08834186035		
1-3/4	8-32	60	100		08834184498		
		80	100		08834184655		
2	8-32	60	100	66261195054	08834184042		
		80	100	66261195055	08834184076		
		100	100		08834184145		
2-1/2	8-32	80	100	66261195056	08834184055		
		100	100		08834184444		
		120	100		08834184818		
3	1/4-20	50	100		08834184041		
		60	100		66261195057		08834184077
		80	100		66261195058		08834184082
		100	100				08834184082
4	1/4-20	120	100	66261195059	08834184344		
		60	100		08834184000		
		100	100		08834184159		
4-1/2	1/4-20	100	100		08834185155		
		120	100		08834184431		
		100	100		08834184302		
5	1/4-20	100	100		08834184302		

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

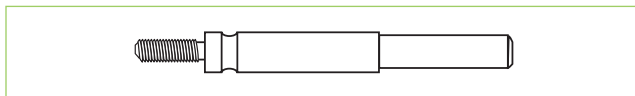
ALL OVERLAP SLOTTED DISCS ARE AVAILABLE (MADE-TO-ORDER) REINFORCED WITH A FIBER WASHER

CERAMIC ALUMINA BLEND AND ALUMINUM OXIDE PLUS OVERLAP SLOTTED DISCS ARE ALSO AVAILABLE UPON REQUEST AS MADE-TO-ORDER PRODUCTS.

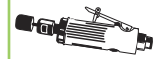
Quick-Change Mandrels for Overlap Slotted Discs, Square and Cross Pads

CROSS PAD SIZE DIA.	SQUARE PAD SIZE DIA.	OAL	MODEL NO.	THD. SIZE	PART #
1/4, 3/8, and 1/2 wide		2-1/2	MM48-4	3-48	08834183162
3/4, 1 wide	Up thru 1-1/2 sq. x 1/2 thick 2 sq. x 1/4 or 3/8 thick	3	MM32-4	8-32	08834183163
		4	MM-32-4-4	8-32	08834121680
		6	MM-32-4-6	8-32	08834121681
All pads 2-1/2 x 1-1/2 and larger	2 sq. x 1/4 or 1/2 thick and larger	3	MM20-4	1/4-20	08834183164

FOR OVERLAP SLOTTED DISCS, CHOOSE A MANDREL WITH THE SAME THREAD SIZE AS THE DISC



EXTENDED MANDREL



CATEGORY DEFINITION

Flaps of abrasive cloth are stacked, inserted into a holder, and then attached to a mandrel. The flaps are designed to break down during use and reveal the next layer of abrasive.

Cloth flaps are mixed with non-woven flaps to create an interleaf bore polisher.

APPLICATIONS: For deburring, sizing, cleaning and polishing the interior diameters of cylinders, tubes and hydraulic fittings. Flaps adjust automatically to inside diameter, polishing the entire surface area with each pass.

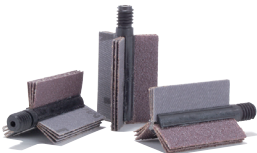




Bore polishers are self-centering, so they apply equal pressure to full wall of inside diameter. Spring action design gives faster inside diameter cleaning, deburring and polishing to cylinders, deep bores and tubes.

Interleafed bore polishers are designed to polish and finish in one easy application. The abrasive flaps cut, while the non-woven flaps apply a fine finish.

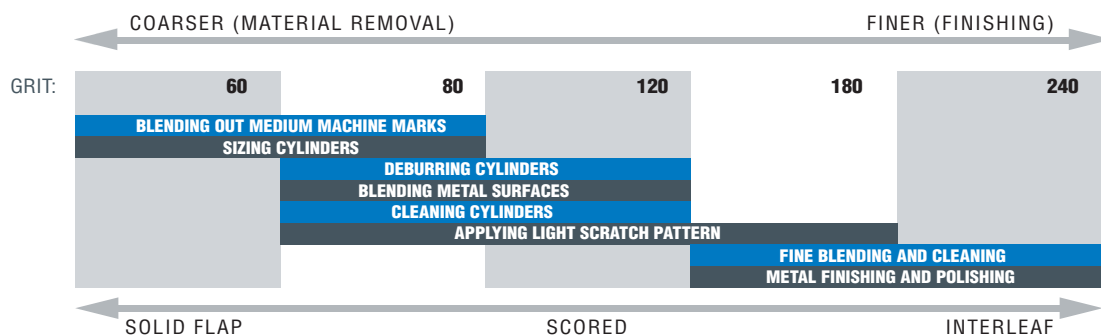
GRIT RANGE: 60 - 240

ABRASIVE GRAIN: Aluminum Oxide

APPLICATION-TO-PRODUCT SHAPE RECOMMENDATION GUIDE

SHAPE	APPLICATION
 <p>Bore Polisher Solid Flaps B-3 Series</p>	<ul style="list-style-type: none"> • For 5/8" to 1" interior diameter bores • 3 abrasive packs 1-1/2" wide, bonded to hub • Use with QC-5 mandrel Part # 08834154182
 <p>Bore Polisher Solid Flaps B-4 Series</p>	<ul style="list-style-type: none"> • For 1" to 4" interior diameter bores • 4 abrasive packs 1-1/2" wide, bonded to hub • Use with BPM-4 mandrel Part # 08834154183
 <p>Bore Polisher Solid Flaps B-8 Series</p>	<ul style="list-style-type: none"> • For 2" to 5-7/8" interior diameter bores • 8 abrasive packs 1-1/2" wide, bonded to hub • Use with BPM-8 mandrel Part # 08834154184
 <p>Bore Polisher Scored Flaps</p>	Available upon request as made-to-order products
 <p>Bore Polisher Interleaf</p>	Cloth flaps are mixed with non-woven flaps. Merit interleaf bore polishers do double duty. Designed to polish and finish in one easy application, they are the ideal choice when close tolerances must be maintained, while giving an interior a polished finish.

APPLICATION/GRIT RECOMMENDATION GUIDE





Merit Aluminum Oxide Bore Polishers

AVAILABILITY

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	X-wt. Cotton/Poly

TIER:	GOOD
BRAND:	Merit
ABRASIVE:	Aluminum Oxide
BACKING:	X-wt. Cotton/Poly

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #	
Bore Polishers – Solid Flap B-3 and B-4 Series					
B-305	60	25,000	10	08834154190	
Fits ID 5/8 to 1	80	25,000	10	08834154191	
	120	25,000	10	08834154193	
	180	25,000	10	08834154195	
	240	25,000	10	08834154197	
B-405	60	22,000	10	08834154091	
	Fits ID 1 to 1-1/2	80	22,000	10	08834154092
		120	22,000	10	08834154093
		180	22,000	10	08834154094
B-410	60	20,000	10	08834154100	
	Fits ID 1-1/2 to 2	80	20,000	10	08834154101
		120	20,000	10	08834154102
		180	20,000	10	08834154103
B-415	60	16,000	10	08834154109	
	Fits ID 2-1/8 to 2-1/2	80	16,000	10	08834154110
		120	16,000	10	08834154111
		180	16,000	10	08834154112
B-420	60	15,000	10	08834154118	
	Fits ID 2-1/2 to 3	80	15,000	10	08834154119
		120	15,000	10	08834154120
		180	15,000	10	08834154121
B-425	60	10,000	10	08834154127	
	Fits ID 3-1/8 to 4	80	10,000	10	08834154128
		120	10,000	10	08834154129
		180	10,000	10	08834154130
	240	10,000	10	08834154131	

SOME MERIT PART NUMBERS ARE NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

DESCRIPTION	GRIT	MAX. RPM	STD. PKG.	PART #	
Bore Polishers – Solid Flap B-8 Series					
B-810	60	16,000	10	08834154136	
Fits ID 2 to 2-1/2	80	16,000	10	08834154137	
	120	16,000	10	08834154138	
	180	16,000	10	08834154139	
	240	16,000	10	08834154140	
B-815	60	15,000	10	08834154145	
	Fits ID 2-5/8 to 3	80	15,000	10	08834154146
		120	15,000	10	08834154147
		180	15,000	10	08834154148
B-820	60	10,000	10	08834154154	
	Fits ID 3-1/8 to 4	80	10,000	10	08834154155
		120	10,000	10	08834154156
		180	10,000	10	08834154157
B-825	60	8,000	10	08834154163	
	Fits ID 4-1/4 to 5-1/4	80	8,000	10	08834154164
		120	8,000	10	08834154165
		180	8,000	10	08834154166
B-830	60	8,000	10	08834154172	
	Fits ID 5-1/4 to 5-7/8	80	8,000	10	08834154173
		120	8,000	10	08834154174
		180	8,000	10	08834154175
	240	8,000	10	08834154176	

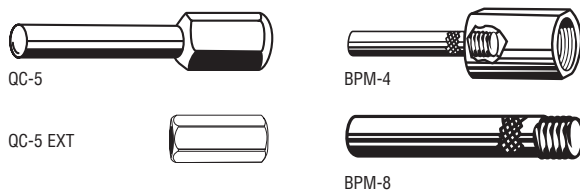
Bore Polishers – Scored Flaps

Available on request as made-to-order products

Bore Polishers – Interleaf

B-405 Interleaf	80	22,000	10	08834150271
Fits ID 1 to 1-1/2	180	22,000	10	08834150273
B-410 Interleaf	80	20,000	10	08834150275
Fits ID 1-1/2 to 2				

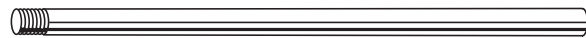
Mandrels for Bore Polishers



DESCRIPTION	MODEL NO.	THREAD	PART #
For B-3 Series	QC-5	5/16-18	08834154182
For B-4 Series	BPM-4	1/2-20	08834154183
For B-8 Series	BPM-8	1/4-20	08834154184
QC-5 Ext.	QC-5 Ext.	5/16-18	08834150573

STANDARD PACKAGE = 1

Extension Mandrels for Bore Polishers



DIAMETER X LENGTH	MODEL NO.	THREAD	PART #
1/4 x 4	EM-144	1/4-20	08834154185
1/4 x 6	EM-146	1/4-20	08834154186
1/4 x 8	EM-148	1/4-20	08834154187

To extend a B-3 series bore polisher, attach the QC-5 Ext. to the bore polisher, then attach the desired length extension mandrel above to the QC-5 Ext. To extend a B-4 series bore polisher, attach the adapter piece of the BPM-4 mandrel to the bore polisher, then attach the desired length extension mandrel above to the BPM-4 adapter piece. To extend a B-8 series bore polisher, attach the desired length extension mandrel above directly to the bore polisher. Standard package = 1.

Test Kit

Merit Bore Polisher Test Kit “BP”

- Part # 08834154181
- Contains ten bore polishers and two mini 1/4"-20 thread flap wheels in assorted sizes and grits for finishing 1" to 5" interior diameters, and mandrel for 1/4" chuck.





CATEGORY DEFINITION

FlexDrum abrasive segments sweep away flaws. Their extreme longevity and perfect balance make them well-suited for automatic as well as offhand use. Hubs and abrasive segments can be combined to fit your job perfectly.

APPLICATIONS	Blending out parting lines on castings, smoothing out pre-ground welded areas, removing burrs and work flaws, graining stainless, brush-finishing and satin-finishing aluminum, removing rust, deflashing molded plastic and rubber parts, and preparing surfaces for painting or plating.
SIZE RANGE:	Diameter of loaded FlexDrum: 8" – 18" Width of FlexDrum: 1-1/2" – 12" Custom die-cut segments as well as extra wide segments, in widths up to 144" are also available as made-to-order products.
GRIT RANGE:	50 – 240
BOND:	Resin or glue
BACKING:	Heavyweight cotton
ABRASIVE GRAIN:	Premium Aluminum Oxide

SHAPE/APPLICATION RECOMMENDATION GUIDE



Plain Segment

- For flat or mildly contoured surfaces



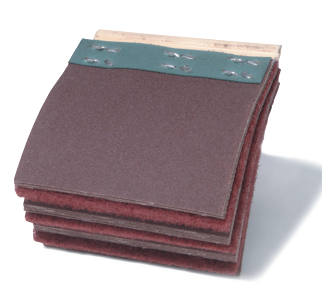
1/4 Scored (SC) Segment

- Great for complex parts
- Provides a fine finish



1/2 Slash (SL) Segment

- Great for mild and moderate contours



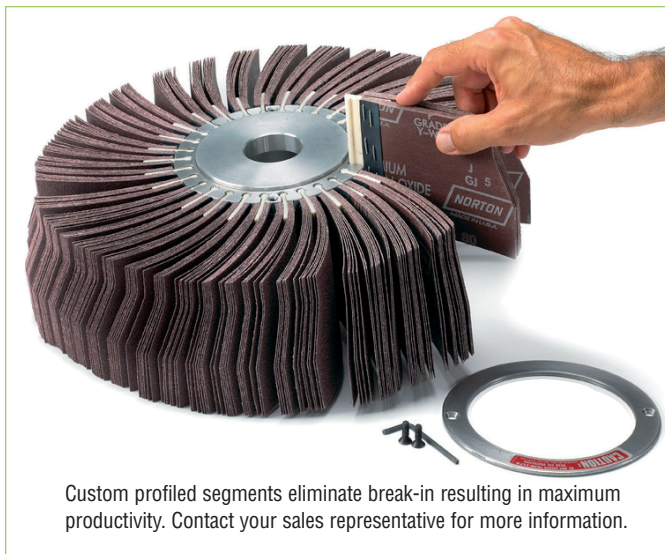
Interleaf Segment

- Available upon request as made-to-order product

LOADING FLEX DRUM HUBS



FlexDrum hub end plate removes for easy loading of abrasive segments.



Custom profiled segments eliminate break-in resulting in maximum productivity. Contact your sales representative for more information.

Plain Segments – for flat or mildly curved surfaces

AVAILABILITY

		GOOD							
<i>TIER:</i>									
<i>BRAND:</i>		Merit	Merit	Merit	Merit	Merit	Merit	Merit	
<i>ABRASIVE:</i>		A/O	A/O	A/O	A/O	A/O	A/O	A/O	
<i>GRIT:</i>		50	60	80	100	120	180	240	
WIDTH	TRIM LENGTH*	STD. PKG.	PART #	PART #	PART #	PART #	PART #	PART #	
1-1/2	2-3/4	12	08834155002	08834155003	08834155004		08834155006	08834155008	08834155010
2	2-3/4	12	08834155013	08834155014	08834155015	08834155016	08834155017	08834155019	
2	4	20	08834155312	08834155313	08834155314	08834155315	08834155316	08834155318	
2	5	20		08834155568	08834155569		08834155571	08834155573	08834155575
3	2-3/4	12	08834155025	08834155026	08834155027	08834155028	08834155029	08834155031	
3	4	20	08834155324	08834155325	08834155326		08834155328	08834155330	
3	5	20		08834155579			08834155582	08834155584	
4	2-3/4	12	08834155036	08834155037	08834155038	08834155039	08834155040	08834155042	08834155044
4	4	20	08834155336	08834155337	08834155338		08834155340	08834155342	08834155344
4	5	20		08834155590			08834155593	08834150390	08834155953

ALL FLEXDRUM SEGMENTS ARE AVAILABLE AS NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

1/4 Scored Segments – for complex parts and provide a fine finish

AVAILABILITY

		GOOD							
<i>TIER:</i>									
<i>BRAND:</i>		Merit	Merit	Merit	Merit	Merit	Merit	Merit	
<i>ABRASIVE:</i>		A/O	A/O	A/O	A/O	A/O	A/O	A/O	
<i>GRIT:</i>		50	60	80	100	120	180	240	
WIDTH	TRIM LTH.*	SCORE	STD. PKG.	PART #	PART #	PART #	PART #	PART #	
1-1/2	2-3/4	1/4	12	08834155082	08834155083	08834155084	08834155085	08834155086	08834155088
2	2-3/4	1/4	12	08834155094	08834155095	08834155096	08834155097	08834155098	08834155100
3	2-3/4	1/4	12	08834155106	08834155107	08834155108	08834155109	08834155110	08834155112
4	2-3/4	1/4	12	08834155117	08834155118	08834155119	08834155120	08834155121	08834155123

ALL FLEXDRUM SEGMENTS ARE AVAILABLE AS NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

1/2 Slashed Segments – for mild and moderate contours

AVAILABILITY

		GOOD							
<i>TIER:</i>									
<i>BRAND:</i>		Merit	Merit	Merit	Merit	Merit	Merit	Merit	
<i>ABRASIVE:</i>		A/O	A/O	A/O	A/O	A/O	A/O	A/O	
<i>GRIT:</i>		50	60	80	100	120	180	240	
WIDTH	TRIM LTH.*	SLASH	STD. PKG.	PART #	PART #	PART #	PART #	PART #	
2	4	1/2	20		08834155420	08834155421	08834155422	08834155423	08834155425
2	5	1/2	20			08834155637		08834155639	
3	4	1/2	20	08834155430	08834155431	08834155432	08834155433	08834155434	08834155436
3	5	1/2	20			08834155648			
4	4	1/2	20	08834155443	08834155444	08834155445	08834155446	08834155447	08834155449
4	5	1/2	20		08834155658	08834155659		08834155661	08834150383

ALL FLEXDRUM SEGMENTS ARE AVAILABLE AS NON-STOCK. ASK YOUR NORTON/MERIT REPRESENTATIVE FOR STOCK/MTO STATUS.

*TRIM LENGTH IS THE ACTUAL USABLE LENGTH OF SEGMENT WHEN LOADED



FlexDrums can be used for polishing large IDs. Just load half the segments with a wheel diameter 1/2" to 1" larger than the ID of your workpiece.

Hub Units

- FlexDrum hubs are perfectly balanced, last indefinitely and are available in widths from 1-1/2" to 12"
- Extra wide widths are available up to 144" as made-to-order products

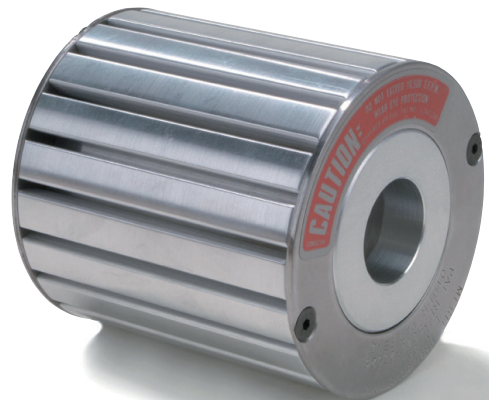
MODEL NO.	D x W	ARBOR HOLE/THREAD	SEGMENTS PER HUB	PART #
FlexDrum Hub Units				
81.5-B	2-3/8 x 1-1/2	1 AH	12	08834140065
82-B	2-3/8 x 2	1 AH	12	08834141049
		5/8-11 THD	12	08834140048
83-B	2-3/8 x 3	1 AH	12	08834141018
		5/8-11 THD	12	08834140034
84-B	2-3/8 x 4	1 AH	12	08834140066
		5/8-11 THD	12	08834140049
122-B	4 x 2	1-1/4 AH	20	08834140050
123-B	4 x 3	1-1/4 AH	20	08834140051
124-B	4 x 4	1-1/4 AH	20	08834140061
142-B	6 x 2	1-1/4 AH	30	08834140062
143-B	6 x 3	1-1/4 AH	30	69957399208
144-B	6 x 4	1-1/4 AH	30	08834141060
840-B2	8 x 2	1-1/4 AH	40	63642592550
840-B4	8 x 4	1-1/4 AH	40	63642592548



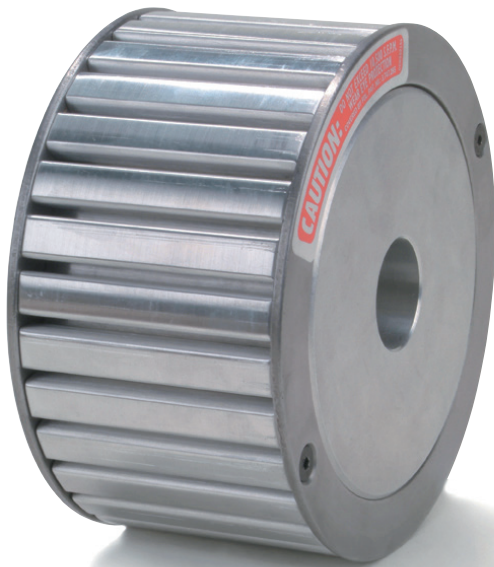
**2-3/8" DIAMETER HUB
WITH 1" ARBOR HOLE**
8" WHEEL WHEN LOADED



**2-3/8" DIAMETER HUB ALSO
AVAILABLE WITH 5/8"-11 ARBOR**
8" WHEEL WHEN LOADED



4" DIAMETER HUB
12" WHEEL WHEN LOADED



8" DIAMETER HUB
16" OR 18" WHEEL WHEN LOADED



6" DIAMETER HUB
14" OR 16" WHEEL WHEN LOADED

FlexDrum Reference Charts

FlexDrums can be mounted on any type of arbor.

Weights

DIAMETER	WEIGHT
Weight of Hubs*	
4" diameter hub	1.5 lbs./inch of width
6" diameter hub	2 lbs./inch of width
8" diameter hub	2.5 lbs./inch of width
Weight of Hubs with Segments*	
4" diameter hub	3.4 - 4 lbs./inch of width
6" diameter hub	5 - 5.5 lbs./inch of width
8" diameter hub	6.75 - 7 lbs./inch of width

*APPROXIMATE VALUES. ACTUAL WEIGHT WILL DEPEND ON ABRASIVE TYPE AND OVERALL WIDTH OF HUB.

FlexDrum Maximum RPM

WHEEL DIAMETER	MAXIMUM RPM
8	4,500
12	3,000
14	2,500
16	2,200
18	2,000

Recommended H.P. Required

HUB	H.P.
4" diameter hub	1/2 H.P./inch of width
6" diameter hub	3/4 H.P./inch of width
8" diameter hub	1 H.P./inch of width

Recommended Surface Feet per Minute for using FlexDrum Wheels on Various Materials

MATERIAL	SFPM
Mild Steel	5,000
Stainless Steel	6,500
Alloy Steel	5,000
Titanium	3,500
Hard Aluminum	5,500
Nonferrous	5,000
Rubber	4,500
Hardwood (edge breaking)	4,000
Softwood	3,500
Thermoplastic	3,000



FlexDrum Hub Specification Chart

	82-B	121-B	141-B	840-B
Diameter of Finished Wheel	8	12	14 or 16	16 or 18
Diameter of Hub Alone	2-3/8	4	6	8
Arbor Hole	1 or 5/8-11 thd	3/4 to 1-3/4	1 to 3-1/2	1-1/4 to 5
Segments Per Hub	12	20	30	40

How to Determine Diameter of Finished FlexDrums

HUB DIAMETER	TRIM LENGTH (X2)	FINISHED WHEEL
2-3/8	2-3/4	8
4	4	12
4	5	14
6	4	14
6	5	16
8	4	16
8	5	18

TECHtip

For surface feet per minute, use the following calculation: SFPM=.262 x DIA (in inches) x RPM.