

### Cartridge Rolls

Shape, port, deburr, finish or polish intricate and hard-to-reach areas with consistent cutting action as the wrapped design wears away to expose fresh abrasive layers.

- ▶ Straight, full taper or sidewall available for varying applications
- ▶ Coated offering includes Ceramic, Aluminum Oxide & Zirconia
- ▶ Aggressive enough for shaping and porting, cushioned for fine polishing



### CA CERAMIC STRAIGHT CARTRIDGE ROLLS

Self-sharpening grains continually produce fresh cutting points, reducing friction and prolonging cut rates. Additional grinding aid further reduces heat, extending life. Multiple layers wear away to expose fresh abrasive material, further extend life.

- ▶ Sharp grains cut easily through stainless steel and alloys
- ▶ Fine cut for refined finishing results
- ▶ Extended wear for reduced downtime



Diameter	Length	Pilot Hole	Max RPM	Optimal RPM	Std. Pkg.	60	80	120
1/4"	1"	1/8"	25,000	20,000	100	<b>49490</b>	<b>48035</b>	<b>49491</b>
1/4"	1-1/2"	1/8"	25,000	20,000	100	<b>49100</b>	<b>49101</b>	<b>49102</b>
3/8"	1-1/2"	1/8"	24,000	16,000	100	<b>49103</b>	<b>47144</b>	<b>49104</b>
1/2"	1-1/2"	1/8"	18,000	12,000	100	<b>49105</b>	<b>49106</b>	<b>49107</b>
3/4"	1-1/2"	3/16"	12,000	8,000	100	49492	<b>49493</b>	49494

Additional Items Available | STOCK ITEMS IN **RED**

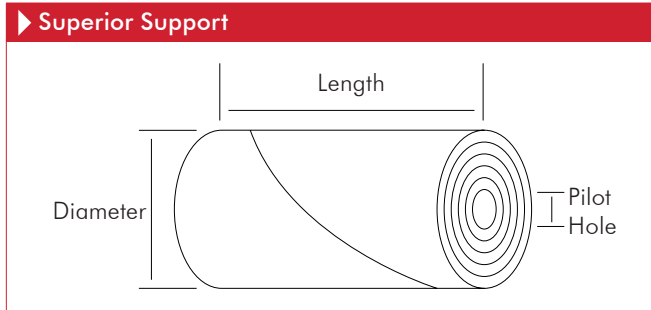
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### Ao ALUMINUM OXIDE STRAIGHT CARTRIDGE ROLLS

General purpose cutting action wears evenly and uniformly, producing a consistent cut on ferrous and non-ferrous metals. Use in straight holes or cylinders or around contoured parts.

- ▶ Remove or shape parts quickly
- ▶ Access intricate areas or small holes
- ▶ Deburr stamped parts



Diameter	Length	Pilot Hole	Max RPM	Optimal RPM	Std. Pkg.	36	60	80	100	120	180	240	320
3/16"	1"	3/32"	25,000	20,000	100	-	18965	<b>11860</b>	<b>18094</b>	<b>11861</b>	<b>18970</b>	<b>18803</b>	18805
1/4"	1"	1/8"	25,000	20,000	100	-	<b>11862</b>	<b>11863</b>	<b>11864</b>	<b>11865</b>	<b>11866</b>	<b>16984</b>	<b>16985</b>
1/4"	1-1/2"	1/8"	25,000	20,000	100	-	<b>11867</b>	<b>11868</b>	<b>11869</b>	<b>11870</b>	<b>11871</b>	<b>16719</b>	<b>16612</b>
1/4"	2"	1/8"	25,000	20,000	100	-	19721	<b>18666</b>	19722	19723	-	19727	55291
5/16"	1"	1/8"	23,000	18,500	100	-	19732	<b>16783</b>	-	<b>18874</b>	17016	32086	49876
5/16"	1-1/2"	1/8"	23,000	18,500	100	-	<b>19741</b>	<b>11872</b>	28232	<b>17068</b>	37515	18567	19745
3/8"	1"	1/8"	24,000	16,000	100	-	<b>11873</b>	<b>11874</b>	19750	<b>11875</b>	<b>11876</b>	<b>19752</b>	<b>17066</b>
3/8"	1-1/2"	1/8"	24,000	16,000	100	-	<b>11877</b>	<b>11878</b>	<b>11879</b>	<b>11880</b>	<b>11881</b>	<b>17160</b>	<b>16703</b>
3/8"	2"	1/8"	24,000	16,000	100	-	<b>21071</b>	<b>18665</b>	21851	23006	-	25636	40828
1/2"	1"	1/8"	18,000	12,000	100	-	<b>11882</b>	<b>11883</b>	<b>11884</b>	<b>11885</b>	<b>11886</b>	<b>18710</b>	<b>16986</b>
1/2"	1-1/2"	1/8"	18,000	12,000	100	<b>11887</b>	<b>11889</b>	<b>11890</b>	<b>11891</b>	<b>11892</b>	<b>11893</b>	<b>11894</b>	<b>11895</b>
1/2"	2"	1/8"	18,000	12,000	100	18716	<b>17167</b>	<b>16642</b>	-	<b>18475</b>	16747	54244	52465
5/8"	1-1/2"	3/16"	15,000	9,500	100	45889	<b>19799</b>	<b>19828</b>	-	19830	-	46224	-
3/4"	1"	3/16"	12,000	8,000	100	-	19852	19853	19854	17007	-	-	-
3/4"	1"	1/4"	12,000	8,000	100	-	17061	16655	16713	16716	-	16717	16718
3/4"	1-1/2"	3/16"	12,000	8,000	100	19878	<b>16069</b>	<b>16704</b>	19880	19881	49284	19885	-
3/4"	1-1/2"	1/4"	12,000	8,000	100	18811	<b>11896</b>	<b>11897</b>	54042	11898	19889	16731	16732
3/4"	2"	1/4"	12,000	8,000	100	-	11899	11900	-	17120	16646	54408	54053
1"	1-1/2"	1/4"	9,000	6,000	100	16165	<b>17006</b>	<b>18604</b>	-	18946	53501	53987	-
1"	2"	1/4"	9,000	6,000	100	18347	<b>11901</b>	<b>11902</b>	16981	11903	-	52193	19977

Additional Items Available | STOCK ITEMS IN RED

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### Ao ALUMINUM OXIDE FULL TAPERED CARTRIDGE ROLLS

Tapered design provides more access and pointed control in concave areas or inside corners. Grind and follow acute seams and welds as the layers wear away to reveal fresh cutting action.

- ▶ Remove or smooth inside corner welds
- ▶ Port and shape concave areas
- ▶ Navigate intricate cast parts



Diameter	Length	Pilot Hole	Max RPM	Optimal RPM	Std. Pkg.	60	80	100	120	180	240	320
3/8"	1"	1/8"	24,000	16,000	100	<b>11904</b>	<b>11905</b>	17139	<b>11906</b>	11907	18585	17165
3/8"	1-1/2"	1/8"	24,000	16,000	100	<b>11908</b>	<b>11909</b>	18808	<b>11910</b>	11911	16029	18850
1/2"	1"	1/8"	18,000	12,000	100	<b>11912</b>	<b>11913</b>	30123	<b>11914</b>	11915	30126	30127
1/2"	1-1/2"	1/8"	18,000	12,000	100	<b>11916</b>	<b>11917</b>	17001	<b>11918</b>	<b>11919</b>	<b>16987</b>	<b>16988</b>
1/2"	2"	1/8"	18,000	12,000	100	16751	<b>20099</b>	-	30091	16841	-	-
5/8"	1-1/2"	3/16"	15,000	9,500	100	38597	16615	55282	44891	-	47486	-
3/4"	1-1/2"	3/16"	12,000	8,000	100	<b>16993</b>	<b>16652</b>	-	16624	-	-	-
1"	1-1/2"	3/16"	9,000	6,000	100	30341	30342	-	42845	-	-	-

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### Ao ALUMINUM OXIDE CARTRIDGE ROLL TEST KIT

Several popular sizes and grits included with associated mandrels, providing everything you need in one convenient cartridge roll test kit.

Diameter	Length	Pilot Hole	Shape	80	120	Std. Pkg.	Part #
1/4"	1"	1/8"	Straight	16	16	1	<b>28802</b>
1/4"	1-1/2"	1/8"	Straight	9	12		
3/8"	1"	1/8"	Straight	6	6		
3/8"	1-1/2"	1/8"	Straight	12	12		
1/2"	1-1/2"	1/8"	Straight	8	8		
3/8"	1-1/2"	1/8"	Tapered	6	-		
1/2"	1-1/2"	1/8"	Tapered	9	-		
For 1" Cartridge Rolls			Mandrel	1			
For 1-1/2" Cartridge Rolls			Mandrel	1			

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