**WARNING**

Always operate, inspect and maintain this tool in accordance with the Safety Code for portable air tools (ANSI B186.1) and any other applicable safety codes and regulations. Please refer to Dynabrade’s Warning/Safety Operating Instructions for more complete safety information.

NOTE: 50971 Lock Ring Wrench is available for removal/installation of 04102 Lock Ring. See inside for Important Operating, Maintenance and Safety Instructions before operating tool.

**Model:**
11000
11001 Versatility Kit
11003 w/Benchmount

**Parts Page Reorder No. PD97-01**
Effective January, 1997
Supersedes PD92-27

Dynafile®
Abrasive Belt Machine.
For serial number 89292 and higher.

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**Diagram:**

- **11007 Idler Arm Assembly (Incl. 11008 Idler Arm and (2) 11011 Idler Wheel Assemblies)**
- **11008 Idler Arm with 95070 Threaded Insert**
- **95070 Threaded Insert**
- **95218 Knob (For mounting contact arm and adjusting belt tracking)**
- **95162 Idler Wheel Mount Screw (2)**
- **11010 Tension Spring (for Idler Arm)**
- **11103 Guard**
- **11040 Spring**
- **01197 Air Motor**
- **01187 Air Motor with 01111 Drive Wheel**
- **50767 Pin**
- **01120 Rotor**
- **01011 Blade (4) (4/pkg.)**
- **01108 Bearing Plate**
- **01017 Pin**
- **04078 Felt Silencer**
- **04078 Lock Ring**
- **04061 Rotor Nut**
- **04087 Shim (3/pkg.) (as required)**
- **01010 Rotor Spacer**
- **01111 Drive Wheel**
- **01107 Bearing**
- **01084 Air Control Ring**
- **01078 Valve Stem**
- **95558 Retaining Ring**
- **95730 O-Ring**
- **01472 Tip Valve**
- **53190 Block Plate**
- **01468 Spring**
- **01464 Seal**
- **01494 Inlet Adapter**
- **01243 Housing**

Please indicate:
Model #, Serial #, and RPM when ordering replacement parts.

**Note:** 01089 Optional Safety Lock Lever available.
Important Operating, Maintenance and Safety Instructions

Carefully read all instructions before operating or servicing any Dynabrade® Abrasive Power Tool.

Warning: Hand, wrist and arm injury may result from repetitive work motion and overexposure to vibration.

Important: All Dynabrade air tools must be used with a Filter-Regulator-Lubricator to maintain all warranties.

Operating Instructions:

Warning: Eye, face and body protection must be worn while operating power tools. Failure to do so may result in serious injury or death. Follow safety procedures posted in workplace.

1. With power source disconnected from tool, securely fasten abrasive/accessory on tool.
2. Install air fitting into inlet bushing of tool. Important: Secure inlet bushing of tool with a wrench before attempting to install the air fitting to avoid damaging valve body housing.
3. Connect power source to tool. Be careful not to depress throttle lever in the process.
4. Check tool speed with tachometer. If tool is operating at a higher speed than the RPM marked on the tool or operating improperly, the tool should be serviced to correct the cause before use.

Maintenance Instructions:

1. Check tool speed regularly with a tachometer. If tool is operating at a higher speed than the RPM marked on the tool, the tool should be serviced to correct the cause before use.
2. Some silencers on air tools may clog with use. Clean and replace as required.
3. All Dynabrade air motors should be lubricated. Dynabrade recommends one drop of air lube per minute for each 10 SCFM (example: if the tool specification state 40 SCFM, set the drip rate of your filter-lubricator at 4 drops per minute). Dynabrade Air Lube (P/N 95842: 1pt. 473ml.) is recommended.
4. An air line filter-regulator-lubricator must be used with this air tool to maintain all warranties. Dynabrade recommends the following: 11289 Air Line Filter-Regulator-Lubricator — Provides accurate air pressure regulation, two-stage filtration of water contaminants and micro-mist lubrication of pneumatic components. Operates 29 SCFM @ 90 PSI has 1/4" NPT female ports.
5. Use only genuine Dynabrade replacement parts. To reorder replacement parts, specify the Model #, Serial #, and RPM of your machine.
6. A motor line-up kit (P/N 96044) is available which includes assorted parts to help maintain motor in peak operating condition.
7. Mineral spirits are recommended when cleaning the tool and parts. Do not clean tool or parts with any solvents or oils containing acids, esters, keytones, chlorinated hydrocarbons or nitro carbons.

Safety Instructions:

Products offered by Dynabrade should not be converted or otherwise altered from original design without expressed written consent from Dynabrade, Inc.

• Important: User of tool is responsible for following accepted safety codes such as those published by the American National Standards Institute (ANSI).
• Operate machine for one minute before application to workpiece to determine if machine is working properly and safely before work begins.
• Always disconnect power supply before changing abrasive/accessory or making machine adjustments.
• Inspect abrasives/accessories for damage or defects prior to installation on tools.
• Please refer to Dynabrade’s Warning/Safety Operating Instructions Tag (Reorder No. 95903) for more complete safety information.
• Warning: Hand, wrist and arm injury may result from repetitive work, motion and overexposure to vibration.

Notice

All Dynabrade motors use the highest quality parts and metals available and are machined to exacting tolerances. The failure of quality pneumatic motors can most often be traced to an unclean air supply or the lack of lubrication. Air pressure easily forces dirt or water contained in the air supply into motor bearings causing early failure. It often scores the cylinder walls and the rotor blades resulting in limited efficiency and power. Our warranty obligation is contingent upon proper use of our tools and cannot apply to equipment which has been subjected to misuse such as unclean air, wet air or a lack of lubrication during the use of this tool.

One Year Warranty

Following the reasonable assumption that any inherent defect which might prevail in a product will become apparent to the user within one year from the date of purchase, all equipment of our manufacture is warranted against defects in workmanship and materials under normal use and service. We shall repair or replace at our factory, any equipment or part thereof which shall, within one year after delivery to the original purchaser, indicate upon our examination to have been defective. Our obligation is contingent upon proper use of Dynabrade tools in accordance with factory recommendations, instructions and safety practices. It shall not apply to equipment which has been subject to misuse, negligence, accident or tampering in any way so as to affect its normal performance. Normally wearable parts such as bearings, sanding pads, rotor blades, etc., are not covered under this warranty.

Machine Length Height Weight Abrasive Belt Size Air Flow Rate Hose Sound Motor Motor Max. SFP(M) Number inch (mm) inch (mm) Pound (kg) Inch (mm) mm SCFM (LPM) Inch (mm) dBA HP (W) RPM RPM

11000 15" (381) 4" (102) 3 lbs. (1.4) 1/8" - 1/2" (3-13) W x 24" (610) L 29 (821) 3/8" (9 mm) 84 dBA .5 (373) 20,000 5,800 (1,762)

Tool also meets these specifications: Air Inlet Thread 1/4" (6 mm) NPT • Air Pressure 90 PSI (6.2 Bars)
Disassembly/Assembly Instructions - Dynafile®

Important: Manufacturer's warranty is void if tool is disassembled before warranty expires.

Notice: A complete tune-up kit, part number 96044, is available which includes assorted parts to help maintain motor in peak condition. These instructions are for use in conjunction with part number 11288 Dynafile Repair Kit, which includes special tools for proper disassembly/assembly of tool. Please refer to parts breakdown for part identification.

To Disassemble:
1. Disconnect tool from power source.
2. Secure 11102 Housing in padded vise.
3. Remove 11103 Guard, abrasive belt, and contact arm assembly.
4. Remove 95216 Pivot Pin, using 8” long, 1/8” diameter drive pin punch (this will release the 11007 Idler Arm Assembly).
5. Remove 11010 Tension Spring.
6. Using 9/64” allen wrench loosen 95311 Screw and remove 01197 Air Motor from 1102 Housing.

Motor Disassembly:
1. Secure 01197 Air Motor in padded vise.
2. Remove 01111 Drive Wheel by inserting a 3/16” hex key through the drive wheel into the end of the 01120 Rotor.
3. Using a pipe wrench or pliers, twist 01111 Drive Wheel counter-clockwise and remove.
4. With an adjustable pin wrench remove 04087 Lock Ring by turning counter-clockwise. Remove 04078 Felt Silencer and air control ring.
5. Remove rotor nut from rotor shaft by inserting a 3/16” hex wrench through body and into rotor shaft. Twist rotor nut from shaft.
6. Pull motor assembly from housing.
7. Remove 01013 Cylinder, blades (4) and spacer from rotor. Note: 01007 Bearing, 01008 Front Bearing Plate and spacer are a slip fit into rotor.
8. Press rotor from 01014 Rear Bearing Plate. Press 01015 Bearing from bearing plate.

Motor reassembly is complete.

Valve Body Disassembly:
1. Position valve body in padded vise using with air inlet facing up.
2. Remove air fitting by securing 04014 Inlet Adapter with a wrench and twist air fitting from inlet adapter. Important: 04014 Inlet Adapter must be secured before attempting to remove air fitting to avoid damaging valve body housing.
3. Remove 53190 Block Plate.
4. Using needle nose pliers, remove 01468 Spring, 01472 Tip Valve and seal.
5. Using a 2.5 mm drift pin, tap 01017 Pin from housing and remove throttle lever.
6. Remove 95558 Retaining Ring using retaining ring pliers.
7. Push 01247 Regulator from valve body housing and remove O-rings.

Disassembly is complete.

Motor Reassembly:
Important: Be sure parts are clean and in good repair before reassembly.
1. Place 01120 Rotor in padded vise with a threaded spindle facing upwards.
2. Slip 01010 Spacer onto rotor.
3. Place a .002” shim into front bearing plate as an initial spacing and slip 01007 Bearing into plate. Note: 01121 Shim Pak contains .001” and .002” shims.
4. Install bearing/bearing plate assembly onto rotor.
5. Install 04081 Rotor Nut onto assembly.
6. Tighten rotor nut onto rotor (torque to 17 N•m/150 in. - lbs.).
7. Check clearance between rotor and bearing plate by using a .001” feeler gauge. Clearance should be at .001” to .0015”. Adjust clearance by repeating steps 1-4 with different shim if necessary.
8. Once proper rotor/gap clearance is achieved, install well lubricated 01011 Blades (4) into rotor slots. Dynabrade air lube P/N 95842 is recommended for lubrication.
9. Install cylinder over rotor. Be sure air inlet holes of cylinder face away from bearing plate.
10. Press 01015 Rear Bearing into 01014 Rear Bearing Plate. Press bearing/bearing plate assembly onto rotor. Be sure that pin and air inlet holes line-up with pin slot and air inlet holes in cylinder. Important: Fit must be snug between bearing plates and cylinder. If too tight, rotor will not turn freely. Rotor must then be lightly tapped at press fit end so it will turn freely while still maintaining a snug fit. A loose fit will not achieve the proper preload of motor bearings.
12. Install motor assembly into housing. Be sure motor drops all the way into housing.
13. Insert air control ring and 04078 Felt Silencer into 04087 Lock Ring and install onto motor housing (torque 17 N•m/150 in. - lbs.).
14. Motor adjustment must now be checked. With motor housing still mounted in vise, pull end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then increase preload or remove shim. Also, push end of rotor and twist (10-15 lbs. force), rotor should turn freely without drag. If drag or rub is felt, then de-load or add shim.
15. Install 10295 Screen and 01111 Drive Wheel.
16. Place 01102 Housing in a padded vise and install 01197 Air Motor.
17. Tighten 95311 Screw with 9/64” allen wrench.

(continued on next page)
18. Install 11010 Tension Spring, 11007 Idler Arm Assembly, and 95216 Pivot Pin

Important: Use 8" long, 1/8" diameter drive pin punch to line-up 11007 Idler Arm Assembly with 01102 Housing.

19. Install 11103 Guard, contact arm assembly and abrasive belt.

Valve Body Reassembly:
1. Insert 01247 Speed Regulator Assembly with O-rings into valve body. Secure with 95558 Retaining Ring.
2. Secure valve body in padded vise with air inlet facing upwards.
3. Insert 01464 Seal into housing.
4. Line up hole in valve stem with hole in housing (looking past brass bushing). Insert 01472 Tip Valve so that the metal pin passes through the hole in the valve stem. Install 01468 Spring (small end towards tip valve).
5. Install 53190 Block Plate into housing.
6. Apply Hernon #940 PST Pipe Sealant to threads of 01494 Inlet Adapter and install valve body (torque 34 N•m/200 in. • lbs.).
7. Install 01093 Throttle Lever and 01017 Pin.

Tool Assembly is complete. Please allow 30 minutes for adhesives to cure before operating tool.

Important: Motor should now be tested for proper operation at 90 PSI. If motor does not operate properly or operates at a higher RPM than marked on the tool, the tool should be serviced to correct the cause before use. Before operating, place 2-3 drops of Dynabrade Air Lube (P/N 95842) directly into air inlet with throttle lever depressed. Operate tool for 30 seconds to determine if tool is operating properly and to allow lubricating oils to properly penetrate motor.

Loctite® is a registered trademark of Loctite Corp.

Abrasive Belt Change and Removal:

To Remove Belt:
1. Remove 11103 Guard by lifting front "lip" and unhooking latches.
2. Gently pull guard back off idler arm to expose internal workings of tool.
3. Depress idler arm lever and pull belt away from the contact wheel.
4. Slip belt over contact wheel.

To Replace Belt:
1. Create a loop with belt by pinching together the sides of belt in the middle.
2. Slip one loop under the 01111 Drive Wheel and around the idler arm.
3. Depress idler arm lever and pull belt toward the contact wheel.
4. Slip belt over contact wheel.
5. Connect tool to power source.
6. Adjust belt tracking using 95218 Knob.

Optional Accessories

Dynaswivel®
Swivels 360° at two locations which allows an air hose to drop straight to the floor, no matter how the tool is held.
• 95460 - 1/4" NPT
• 95461 - 3/8" NPT
• 95460 - 1/2" NPT
• 95734 - 1/4" NPT Flow Control
• 95852 - 1/8" NPT x 1/4" NPT

96044 Motor Tune-Up Kit:
• Includes assorted parts to help maintain motor in tip-top shape.
Dynafiler® Standard Contact Arms
Standard Contact Arms allow for a 4” workable reach.

11212
Belt Size: 1/4" W x 24" L.
11066 Contact Wheel: 5/16" diameter x 1/8" wide, steel.
11034 Platen: 1/4" wide.
File round openings as small as 7/16". 45 PSI maximum.

11213
See 11239 for heavy-duty version. 45 PSI maximum.

11214
Belt Size: 1/2" W x 24" L.
11068 Contact Wheel: 5/16" diameter x 1/8" wide, steel.
11027 Platen: 1/2" wide.
Work on contact wheel or Dynapad®. 45 PSI maximum.

11215
Belt Size: 1/2" W x 24" L.
11070 Contact Wheel: 7/16" diameter x 3/8" wide, rubber.
11025 Platen: 1/2" wide.
Enter 1/2" x 1/2" openings.

11216
Belt Size: 1/4" W x 24" L.
11072 Contact Wheel: 7/16" diameter x 1/8" wide, brass.
11034 Platen: 1/4" wide.
Enter 5/16" x 3/4" openings.

11217
Belt Size: 1/2" W x 24" L.
11074 Contact Wheel: 5/8" diameter x 1/8" wide, rubber.
11032 Platen: 1/4" wide.
Enter channels as narrow as 9/16".

11218
Belt Size: 1/2" W x 24" L.
11076 Contact Wheel: 7/16" diameter x 3/8" wide, steel.
11027 Platen: 1/2" wide.
Standard arm on model 11000. See 11228 for heavy-duty version.

11219
Belt Size: 1/4" or 1/2" W x 24" L.
11080 Contact Wheel: 1" diameter x 3/8" wide, radiused rubber.
11027 Platen: 1/2" wide.
Offset for slack polishing
Grind radiuses, slack polish.

11228 Heavy-Duty Steel
Optional 11028 Steel Platen available for grinding.

11229
Belt Size: 1/2" W x 24" L.
11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.
11025 Platen: 1/2" wide.
See 11243 for heavy-duty version.

11231
Belt Size: 1/4" or 1/2" W x 24" L.
11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.
11135 Platen: 1/2" wide.

11232 For 1/8" Wide Belts
Belt Size: 1/8" or 1/4" W x 24" L.
11086 Contact Wheel: 1" diameter x 3/8" wide, tapered urethane.
11135 Platen: 1/2" wide.
V-Tapered
No platen due to offset design. Grind corners, strap polish.

11233 Heavy-Duty Steel
Grind over contact wheel or Dynapad®.

11234 Heavy-Duty
Belt Size: 1/2" W x 24" L.
11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.
11135 Platen: 1/2" wide.
Grind in narrow areas. 45 PSI maximum.

11235 Heavy-Duty
Belt Size: 1/2" W x 24" L.
11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.
11135 Platen: 1/2" wide.
See 11243 for heavy-duty version.

11228 Heavy-Duty Steel
Optional 11028 Steel Platen available for grinding.

11239 Heavy-Duty Steel
Grind over contact wheel or Dynapad®.

11239 Heavy-Duty Steel
Belt Size: 1/8" or 1/4" W x 24" L.
11086 Contact Wheel: 1" diameter x 3/8" wide, tapered urethane.
11135 Platen: 1/2" wide.
V-Tapered
No platen due to offset design. Grind corners, strap polish.

11243 Heavy-Duty
Grind over contact wheel or Dynapad®.

11244 Heavy-Duty
Belt Size: 1/2" W x 24" L.
11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.
11135 Platen: 1/2" wide.
Grind in narrow areas. 45 PSI maximum.

11251 Heavy-Duty
Belt Size: 1/2" W x 24" L.
11084 Contact Wheel: 3/4" diameter x 1/2" wide, rubber.
11135 Platen: 1/2" wide.
See 11243 for heavy-duty version.

11262 “Offset Arm”
Belt Size: 1/2" W x 24" L.
11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.
11025 Platen: 1/2" wide.
For flat grinding using platen at or near corners and edges of large radius round. Contact wheel is offset to prevent gouging.
Dynafiler® Specialized Contact Arms

Designed to solve tough production problems.

11237 and 11238 Turbine Blade Arms

11237: 1/4" wide x 24" long belts.
11066 Contact Wheel: 5/16" dia. x 1/8" wide steel wheel.
11238: 1/2" wide x 24" long belts.
Contact Wheel: 1/4" dia. x 3/8" wide steel wheel.

11234 Double-Burrer Arm

• Deburs both edges of workpiece simultaneously.
• Contact wheels adjust for material 1/8" to 5/8" thick.

Belt Size: 1/2" wide x 34" long.
11080 Contact Wheels: 1" diameter x 3/8" wide, rubber.

11240, 11241, 11244 and 11245 Extra-Length Arms

11255 Cross-Bow Arm

• I.D. polishing or deburring with one 180° wrist turn.
• Deburr leading radius of 1" to 4" round openings.

Belt Size: 1/2" W x 34" L.

11257, 11178 and 11179 Spear Arms

11257: Custom-made. Specify usable length up to 32".
Specify 11068 - 5/16" diameter steel or 11078 - 5/8" diameter rubber contact wheel.
11178: Has 9" reach with 11068 - 5/16" diameter steel contact wheel.
Belt Size: 1/2" W x 34" L (45 PSI Max.).
11179: Has 9" reach with 11078 - 5/8" diameter rubber contact wheel.
Belt Size: 1/2" W x 34" L.

11258 Stroke Sander Arm

Blend stainless steel.

Belt Size: 1/2" W x 24" L.
11078 Contact Wheel: 5/8" diameter x 3/8" wide, rubber.
Platen: 1/2" W x 7/8" L.

11254 Big Wheel Arm

• Grinds and polishes deep slots or narrow grooves.
• 1/4" to 1/2" wide wheels, 2-1/8" to 4-3/4" diameter (specify size).

Belt Size: 1/4" to 1/2" W x 34" L.

11297 Guide-Cut Arm

• Guide wheels prevent undercutting.
• Removes raised material within .020" or less.
• Use 60 to 80 grit abrasive belts with this arm.

Belt Size: 1/2" W x 24" L, 60 to 80 grit.
11090 Contact Wheel: 5/8" diameter x 3/8" wide rubber.
<table>
<thead>
<tr>
<th>Part Number</th>
<th>Abrasive Belt Size</th>
<th>Contact Wheel Description</th>
<th>Comments</th>
<th>Contact Wheel Assembly</th>
<th>Contact Wheel Only</th>
<th>Bearing (2) Req. Shaft</th>
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<td>11051</td>
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<td>H.D. Version of 11218 Arm</td>
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<td>11079 (2)</td>
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<td>1/2&quot; x 24&quot;</td>
<td>3/4&quot; Dia. x 1/2&quot; W Rubber</td>
<td>H.D. Version of 11213 Arm</td>
<td>11084</td>
<td>11083</td>
<td>11052</td>
</tr>
<tr>
<td>11244</td>
<td>1/2&quot; x 44&quot;</td>
<td>5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>1/2&quot; W Platen - 14&quot; Reach</td>
<td>11078</td>
<td>11077</td>
<td>11052</td>
</tr>
<tr>
<td>11245</td>
<td>1/4&quot; x 44&quot;</td>
<td>5/8&quot; Dia. x 1/8&quot; W Rubber</td>
<td>1/4&quot; W Platen - 14&quot; Reach</td>
<td>11074</td>
<td>11073</td>
<td>11052 (1)</td>
</tr>
<tr>
<td>11254</td>
<td>1/2&quot; or 1/4&quot; x 34&quot;</td>
<td>4-3/4&quot; or 2-1/8&quot; Dia. to 1/4&quot; or 1/2&quot; W</td>
<td>Grind in Deep Narrow Slots</td>
<td>Variable</td>
<td>Variable</td>
<td>11013 (1) 95162</td>
</tr>
<tr>
<td>11255</td>
<td>1/2&quot; x 34&quot;</td>
<td>5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>&quot;Spear-Arm&quot; - Specify length up to 32&quot;</td>
<td>11068 (Steel Rubber)</td>
<td>11067 Steel Rubber</td>
<td>11051 Steel 11054</td>
</tr>
<tr>
<td>11257</td>
<td>1/2&quot; Wide</td>
<td>5/16&quot; Dia. x 3/8&quot; W Steel or 5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>&quot;Deburr I.D. 1&quot; to 4&quot;</td>
<td>11078 (Steel Rubber)</td>
<td>11077 Steel Rubber</td>
<td>11051 Steel 11052 Rubber</td>
</tr>
<tr>
<td>11258</td>
<td>1/2&quot; x 24&quot;</td>
<td>1/2&quot; Dia. x 3/8&quot; W Steel and 5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>&quot;Platen Between 2 Contact Wheels&quot;</td>
<td>11076 Steel Rubber</td>
<td>11075 Steel Rubber</td>
<td>11052 (4) 11054 (2)</td>
</tr>
<tr>
<td>11261</td>
<td>1/2&quot; x 24&quot;</td>
<td>5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>&quot;Banana Arm&quot; – For in-line scratch pattern.</td>
<td>11078</td>
<td>11077</td>
<td>11052</td>
</tr>
<tr>
<td>11262</td>
<td>1/2&quot; x 24&quot;</td>
<td>5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>&quot;Offset Arm&quot; – Contact wheel is offset to prevent gouging</td>
<td>11078</td>
<td>11077</td>
<td>11052</td>
</tr>
<tr>
<td>11297</td>
<td>1/2&quot; x 24&quot;</td>
<td>5/8&quot; Dia. x 3/8&quot; W Rubber</td>
<td>Contains two 11395 Guide Wheels. Prevents undercutting</td>
<td>11090</td>
<td>11077</td>
<td>11052 95610 11054</td>
</tr>
</tbody>
</table>