

# Flex Drum

FLEXDRUM



**FlexDrum's abrasive cloth sweeps away flaws. Its extreme longevity and perfect balance make it well-suited for automatic as well as off-hand use.**

Saves time and costs in operations such as 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.

Hubs and abrasive segments can be combined to fit your job perfectly. A wide selection of grits from 50 to 320, are available in resin or glue bond. Diameters in "B" type from 8" to 16" and widths from 1-1/2" to 12" are available. Also available are Custom Die-Cut Loadings as well as Extra Wide types in widths up to 144".



**Tip**

Merit Flex-Drum segments feature a high performance coated abrasive, designed for superior life with an aggressive cut. Heavy cotton backing and premium abrasive grain combine to provide industry-leading performance on a wide range of polishing and finishing applications!

# Plain Segments – ALO Resin Bond

## FLEXDRUM SEGMENTS ALO RESIN BOND PLAIN

WIDTH	TRIM	GRIT	PART #
1-1/2" 12/box	2-3/4"	50	08834155002
		60	08834155003
		80	08834155004
		100	08834155005
		120	08834155006
		180	08834155008
2" 12/box	2-3/4"	240	08834155010
		50	08834155013
		60	08834155014
		80	08834155015
		100	08834155016
		120	08834155017
2" 20/box	4"	180	08834155019
		50	08834155312
		60	08834155313
		80	08834155314
		100	08834155315
		120	08834155316
2" 20/box	5"	180	08834155318
		60	08834155568
		80	08834155569
		120	08834155571
		180	08834155573
		240	08834155575
3" 12/box	2-3/4"	50	08834155025
		60	08834155026
		80	08834155027
		100	08834155028
		120	08834155029
		180	08834155031

## FLEXDRUM SEGMENTS ALO RESIN BOND PLAIN (CONTINUED)

WIDTH	TRIM	GRIT	PART #
3" 20/box	4"	50	08834155324
		60	08834155325
		80	08834155326
		120	08834155328
		180	08834155330
3" 20/box	5"	60	08834155579
		120	08834155582
		180	08834155584
4" 12/box	2-3/4"	50	08834155036
		60	08834155037
		80	08834155038
		100	08834155039
		120	08834155040
		180	08834155042
4" 20/box	4"	240	08834155044
		50	08834155336
		60	08834155337
		80	08834155338
		100	08834155339
		120	08834155340
4" 20/box	5"	180	08834155342
		240	08834155344
		60	08834155590
		80	08834155591
		120	08834155593
		180	08834150390
4" 20/box	5"	240	08834155953

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**Plain Segment  
for flat or mildly  
contoured surfaces**



**Tip** Flex Drums 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 work piece

# Scored and Slashed Segments

## SCORED (1/4") & SLASHED (1/2") FLEXDRUM SEGMENTS ALO RESIN BOND

WIDTH	TRIM	SC/SL	GRIT	PART #
1-1/2" 12/box	2-3/4"	1/4" SC	50	08834155082
			60	08834155083
			80	08834155084
			100	08834155085
			120	08834155086
			180	08834155088
2" 12/box	2-3/4"	1/4" SC	240	08834155090
			50	08834155094
			60	08834155095
			80	08834155096
			100	08834155097
			120	08834155098
2" 20/box	4"	1/2" SL	180	08834155100
			240	08834155102
			60	08834155420
			80	08834155421
			100	08834155422
			120	08834155423
			180	08834155425
			240	08834155427

## SCORED (1/4") & SLASHED (1/2") (CONTINUED) FLEXDRUM SEGMENTS ALO RESIN BOND

WIDTH	TRIM	SC/SL	GRIT	PART #
2" 20/box	5"	1/2" SL	50	08834155635
			80	08834155637
			120	08834155639
3" 12/box	2-3/4"	1/4" SC	50	08834155106
			60	08834155107
			80	08834155108
			100	08834155109
			120	08834155110
3" 20/box	4"	1/2" SC	180	08834155112
			50	08834155430
			60	08834155431
			80	08834155432
			100	08834155433
			120	08834155434
3" 20/box	5"	1/2" SL	180	08834155436
			240	08834155438
			50	08834155646
			80	08834155648

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**FlexDrum Hub End Plate removes for easy loading of abrasive segments**



**Plain Segment for flat or mildly contoured surfaces**

**SCORED (1/4") & SLASHED (1/2") (CONTINUED)  
FLEXDRUM SEGMENTS ALO RESIN BOND**

WIDTH	TRIM	SC/SL	GRIT	PART #
4" 12/box	2-3/4"	1/4" SC	50	08834155117
			60	08834155118
			80	08834155119
			100	08834155120
			120	08834155121
4" 20/box	4"	1/2" SL	50	08834155443
			60	08834155444
			80	08834155445
			100	08834155446
			120	08834155447
4" 20/box	5"	1/2" SL	180	08834155449
			240	08834155451
			60	08834155658
			80	08834155659
4" 20/box			120	08834155661
			180	08834150383

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



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**1/4" Scored (SC)**  
great for complex parts and provides a fine finish



**1/2" Slash (SL)**  
great for mild and moderate contours



**Interleaf Segment**  
(available upon request)

# Hub Units

FlexDrum Hubs are perfectly balanced, last indefinitely and are available in widths from 1-1/2" to 12". Extra Wide widths available up to 144".

## FLEXDRUM HUB UNITS

MODEL # DIA. X WIDE	ARBOR HOLE	SEGMENT PER HUB	PART #
81.5-B 2-3/8" x 1-1/2"	1" AH	12	08834140065
82-B 2-3/8" x 2"	1" AH 5/8-11	12	08834141049 08834140048
83-B 2-3/8" x 3"	1" AH 5/8-11	12	08834141018 08834140034
84-B 2-3/8" x 4"	1" AH 5/8-11	12	08834140066 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

# Reference Charts

FlexDrum can be mounted on any type of arbor.

WEIGHTS	
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 Loadings*	
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
Non Ferrous	5,000
Rubber	4,500
Hardwood (edge breaking)	4,000
Softwood	3,500
Thermoplastic	3,000

**Tip** For surface feet per minute, use the following calculation:  
 $SFPM = .262 \times DIA \text{ (in inches)} \times RPM.$



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	12	20	30	40



HOW TO DETERMINE SIZE OF FINISHED FLEXDRUM			
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"

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