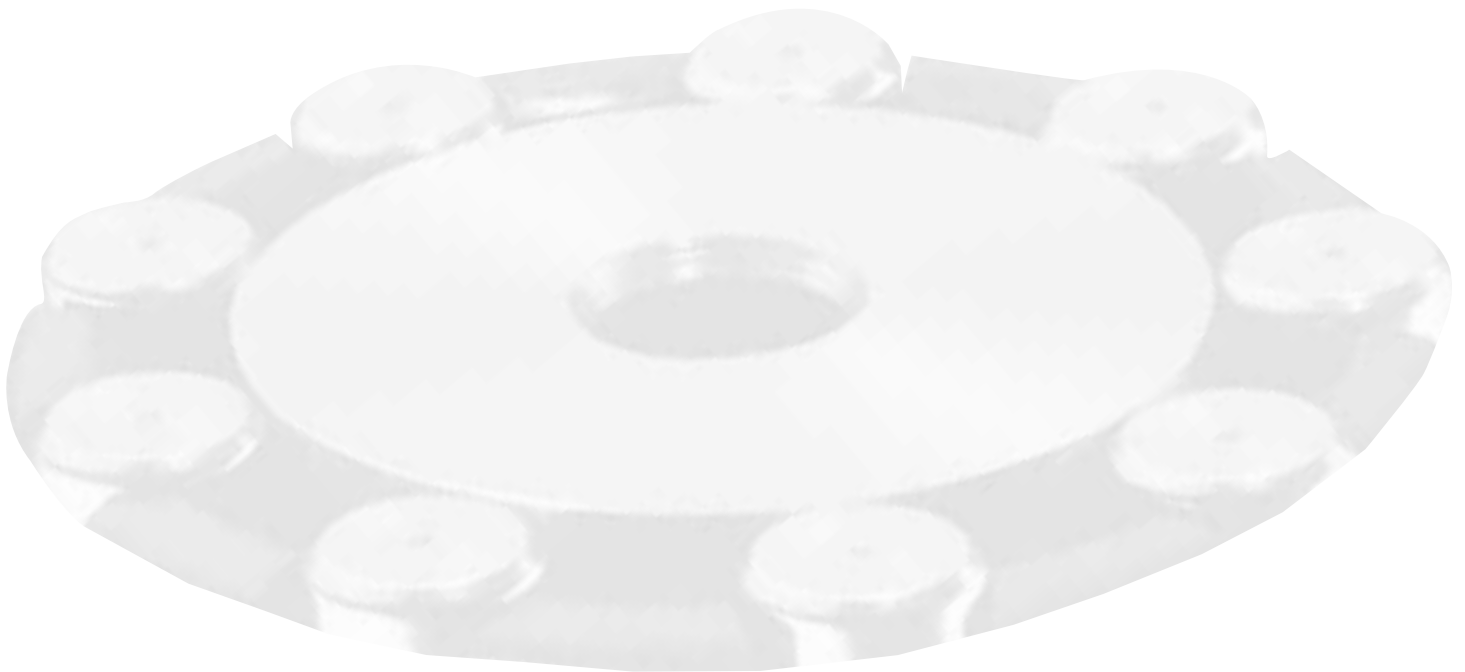


## **COGSDILL TOOL**

*This booklet contains schematic drawings and complete details listings for our standard internal and external Roll-a-Finish® tools. It is a technical supplement to our full catalog.*

*The full catalog contains more information on our Roll-a-Finish tools, as well as an overview of the roller burnishing process and tool operating parameters. The catalog also contains information on other burnishing products from Cogsdill (refer to the inside back cover of this booklet).*

*Request Catalog no. 500, Burnishing Tools & Machines.*



# Burnishing

Roll-a-Finish®

TOOLS

Bill of Materials

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<u>19</u>	<u>AEX SERIES EXTERNAL TOOLS</u>

SR series

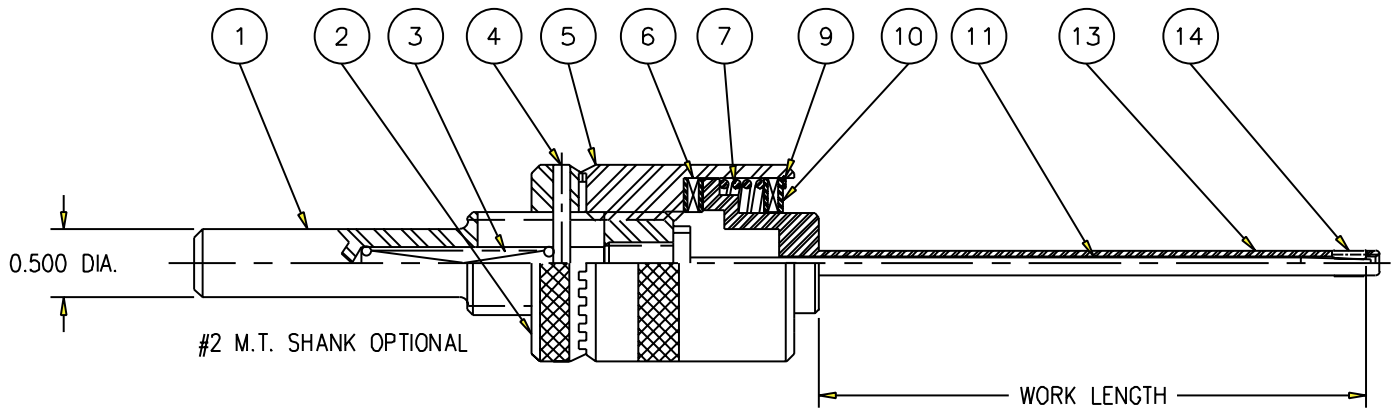
Internal Roll-a-Finish® tools



# Internal Roll-a-Finish® tools

# SR series

“SR-188 ~ SR-242” SERIES ROLL-A-FINISH® TOOLS 3/16 TO 1/4 IN. (4.76 TO 6.35mm)



\* FOR SELF FEEDING HELIX TOOL  
 DESIGNATE DET #13 WITH 'H'  
 eg: SRH-188

SR-188 ADJUSTMENT ASSEMBLY

TOOL SIZE	1 SHANK	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	9 SPIROLOX	10 THRUST RACE
SR-188									
THRU	RA-500	RA-500	RA-500	RA-500	RA-500	SR-500	SR-188	SR-500	SR-500
SR-242						2 REQD			4 REQD

MANDREL ASSEMBLY  
2" WORK LENGTH

TOOL SIZE	11 MANDREL	13 CAGE *	14 ROLL	NO REQD
SR-188	SR-188	SR-188		
SR-195	SR-195	SR-195		
SR-203	SR-203	SR-203		
SR-211	SR-211	SR-211	SR-187	3
SR-219	SR-219	SR-219		
SR-226	SR-226	SR-226		
SR-234	SR-234	SR-234		
SR-242	SR-242	SR-242		

MANDREL ASSEMBLY  
4" WORK LENGTH

TOOL SIZE	11 MANDREL	13 CAGE *	14 ROLL	NO REQD
SR-188-4	SR-188-4	SR-188-4		
SR-195-4	SR-195-4	SR-195-4		
SR-203-4	SR-203-4	SR-203-4		
SR-211-4	SR-211-4	SR-211-4	SR-187	3
SR-219-4	SR-219-4	SR-219-4		
SR-226-4	SR-226-4	SR-226-4		
SR-234-4	SR-234-4	SR-234-4		
SR-242-4	SR-242-4	SR-242-4		

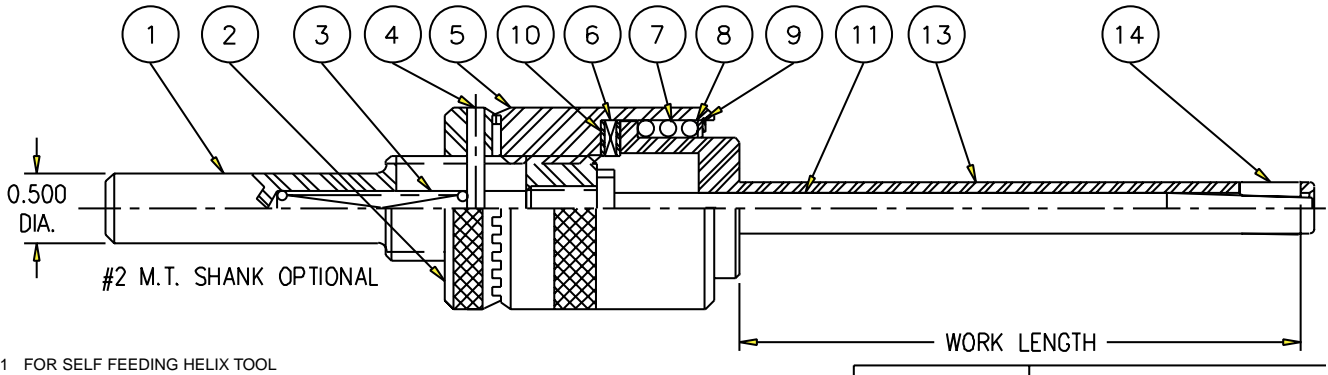
MANDREL ASSEMBLY  
6" WORK LENGTH

TOOL SIZE	11 MANDREL	13 CAGE *	14 ROLL	NO REQD
SR-188-6	SR-188-6	SR-188-6		
SR-195-6	SR-195-6	SR-195-6		
SR-203-6	SR-203-6	SR-203-6		
SR-211-6	SR-211-6	SR-211-6	SR-187	3
SR-219-6	SR-219-6	SR-219-6		
SR-226-6	SR-226-6	SR-226-6		
SR-234-6	SR-234-6	SR-234-6		
SR-242-6	SR-242-6	SR-242-6		

# SR series

# Internal Roll-a-Finish® tools

“SR-250 ~ SR-484” SERIES ROLL-A-FINISH® TOOLS 1/4 TO 1/2 IN. (6.35 TO 12.70mm)



- 1 FOR SELF FEEDING HELIX TOOL  
DESIGNATE DET #13 WITH 'H'  
eg: SRH-250
- 2 FOR BOTTOMING TOOLS DESIGNATE  
DET #13 & #14 WITH "B"  
eg: SRB-312 & B-312 RESPECTIVELY
- 3 FOR SELF FEEDING HELIX TOOL  
USE 'R' ROLLS DET #14 eg: R-250
- 4 TOOLS SRB-250 THRU SRB-297  
USE RB-120 ROLL

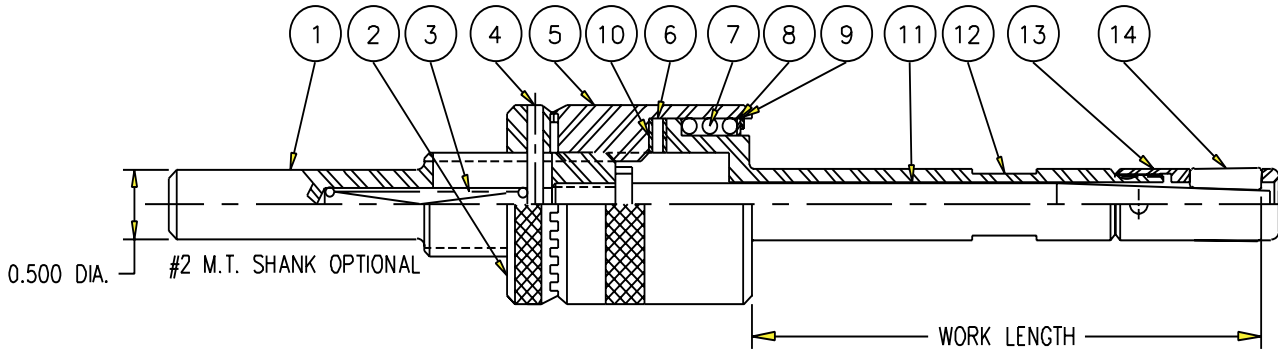
TOOL SIZE	SR-500 ADJUSTMENT ASSEMBLY									
	1 SHANK	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 WASHER	9 SPIROLOX	10 THRUST RACE
SR-250										
THRU	RA-500	RA-500	RA-500	RA-500	RA-500	SR-500	SR-500	SR-500	SR-500	SR-500
SR-484						1 REQD				2 REQD

TOOL SIZE	MANDREL ASSEMBLY 2" WORK LENGTH				MANDREL ASSEMBLY 4" WORK LENGTH				MANDREL ASSEMBLY 6" WORK LENGTH			
	11 MANDREL	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD
SR-250	SR-250	SR-250			SR-250-4	SR-250-4			SR-250-6	SR-250-6		
SR-266	SR-266	SR-266	SR-250	5	SR-266-4	SR-266-4	SR-250	5	SR-266-6	SR-266-6	SR-250	5
SR-281	SR-281	SR-281			SR-281-4	SR-281-4			SR-281-6	SR-281-6		
SR-297	SR-297	SR-297			SR-297-4	SR-297-4			SR-297-6	SR-297-6		
SR-312	SR-312	SR-312			SR-312-4	SR-312-4			SR-312-6	SR-312-6		
SR-328	SR-328	SR-328			SR-328-4	SR-328-4			SR-328-6	SR-328-6		
SR-344	SR-344	SR-344	SR-312	5	SR-344-4	SR-344-4	SR-312	5	SR-344-6	SR-344-6	SR-312	5
SR-359	SR-359	SR-359			SR-359-4	SR-359-4			SR-359-6	SR-359-6		
SR-375	SR-344	SR-375			SR-344-4	SR-375-4			SR-344-6	SR-375-6		
SR-391	SR-359	SR-391			SR-359-4	SR-391-4			SR-359-6	SR-391-6		
SR-406	SR-406	SR-406			SR-406-4	SR-406-4			SR-406-6	SR-406-6		
SR-422	SR-422	SR-422	SR-375	5	SR-422-4	SR-422-4	SR-375	5	SR-422-6	SR-422-6	SR-375	5
SR-438	SR-438	SR-438			SR-438-4	SR-438-4			SR-438-6	SR-438-6		
SR-453	SR-453	SR-453			SR-453-4	SR-453-4			SR-453-6	SR-453-6		
SR-469	SR-469	SR-469			SR-469-4	SR-469-4			SR-469-6	SR-469-6		
SR-484	SR-484	SR-484			SR-484-4	SR-484-4			SR-484-6	SR-484-6		

# Internal Roll-a-Finish® tools

# SR series

“SR-500 ~ SR 969” SERIES ROLL-A-FINISH® TOOLS 1/2 TO 1 IN. (12.70 TO 25.40mm)



- 1 FOR SELF FEEDING HELIXTOOL  
USE 'R' CAGES DET #13 eg: R-500
- 2 FOR BOTTOMING TOOLS USE 'B'  
CAGES DET #13 eg: B-500
- 3 FOR SELF FEEDING HELIX TOOL  
USE 'R' ROLLS DET #14 eg: R-500
- 4 FOR BOTTOMING TOOLS USE 'B'  
ROLLS DET #14 eg: B-500

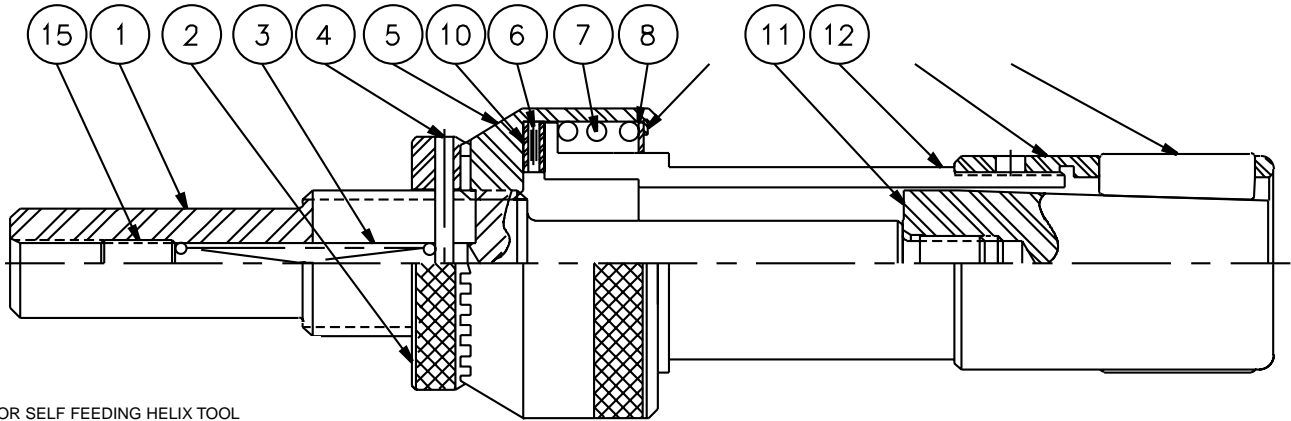
TOOL SIZE	SR-500 ADJUSTMENT ASSEMBLY									
	1 SHANK	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 WASHER	9 SPIROLOX	10 THRUST RACE
SR-500										
THRU	RA-500	RA-500	RA-500	RA-500	RA-500	SR-500	SR-500	SR-500	SR-500	SR-500
SR-969						1 REQD				2 REQD

TOOL SIZE	MANDREL ASSEMBLY 2" WORK LENGTH					MANDREL ASSEMBLY 4" WORK LENGTH					MANDREL ASSEMBLY 6" WORK LENGTH					MANDREL ASSEMBLY 8" WORK LENGTH				
	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD
SR-500	SR-500	SR-500	SR-500			SR-500-4	SR-500-4	SR-500			SR-500-6	SR-500-6	SR-500			SR-500-8	SR-500-8	SR-500		
SR-531	SR-531	SR-500	SR-531			SR-531-4	SR-500-4	SR-531			SR-531-6	SR-500-6	SR-531			SR-531-8	SR-500-8	SR-531		
SR-562	SR-562	SR-562	SR-562			SR-562-4	SR-562-4	SR-562			SR-562-6	SR-562-6	SR-562			SR-562-8	SR-562-8	SR-562		
SR-594	SR-594	SR-562	SR-594			SR-594-4	SR-562-4	SR-594			SR-594-6	SR-562-6	SR-594			SR-594-8	SR-562-8	SR-594		
SR-625	SR-625	SR-625	SR-625	SR-500		SR-625-4	SR-625-4	SR-625	SR-500		SR-625-6	SR-625-6	SR-625	SR-500		SR-625-8	SR-625-8	SR-625	SR-500	
SR-656	SR-656	SR-656	SR-656			SR-656-4	SR-656-4	SR-656			SR-656-6	SR-656-6	SR-656			SR-656-8	SR-656-8	SR-656		
SR-688	SR-688	SR-688	SR-688			SR-688-4	SR-688-4	SR-688			SR-688-6	SR-688-6	SR-688			SR-688-8	SR-688-8	SR-688		
SR-719	SR-719	SR-719	SR-719			SR-719-4	SR-719-4	SR-719			SR-719-6	SR-719-6	SR-719			SR-719-8	SR-719-8	SR-719		
SR-750	SR-750	SR-750	SR-750	5		SR-750-4	SR-750-4	SR-750	5		SR-750-6	SR-750-6	SR-750	5		SR-750-8	SR-750-8	SR-750	5	
SR-781	SR-781	SR-750	SR-781			SR-781-4	SR-750-4	SR-781			SR-781-6	SR-750-6	SR-781			SR-781-8	SR-750-8	SR-781		
SR-812	SR-812	SR-812	SR-812			SR-812-4	SR-812-4	SR-812			SR-812-6	SR-812-6	SR-812			SR-812-8	SR-812-8	SR-812		
SR-844	SR-844	SR-812	SR-844			SR-844-4	SR-812-4	SR-844			SR-844-6	SR-812-6	SR-844			SR-844-8	SR-812-8	SR-844		
SR-875	SR-875	SR-875	SR-875			SR-875-4	SR-875-4	SR-875			SR-875-6	SR-875-6	SR-875			SR-875-8	SR-875-8	SR-875		
SR-906	SR-906	SR-875	SR-906			SR-906-4	SR-875-4	SR-906			SR-906-6	SR-875-6	SR-906			SR-906-8	SR-875-8	SR-906		
SR-938	SR-938	SR-906	SR-938			SR-938-4	SR-906-4	SR-938			SR-938-6	SR-906-6	SR-938			SR-938-8	SR-906-8	SR-938		
SR-969	SR-969	SR-906	SR-969			SR-969-4	SR-906-4	SR-969			SR-969-6	SR-906-6	SR-969			SR-969-8	SR-906-8	SR-969		

# SR series

# Internal Roll-a-Finish® tools

“SR-1000 ~ SR-1594” SERIES ROLL-A-FINISH® TOOLS 1 TO 1-5/8 IN. (25.4 TO 41.28mm)



1 FOR SELF FEEDING HELIX TOOL  
USE 'R' CAGES DET #13 eg: R-1000

2 FOR BOTTOMING TOOLS USE 'B' CAGES  
DET #13 eg: RB-1000

3 FOR SELF FEEDING HELIX TOOL  
USE 'R' ROLLS DET #14 eg: R-875

4 FOR BOTTOMING ROLLS USE 'B' ROLLS  
DE #14 eg: B-875

5 FOR ALTERNATE WORK LENGTHS  
DESIGNATE SHANK WITH -4, -6 & -8

SR-1000 ADJUSTMENT ASSEMBLY

TOOL SIZE	1 SHANK (5)	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 WASHER	9 SPIROLOX	10 THRUST RACE	15 SET SCREW
SR-1000	RA-1000	RA-1000	U-HAN	1/8 DIA	RA-1000	TORR	NSR-1000	SR-1000	RR-193	TORR	5/16
THRU			H-49	x 1 1/2		NTA-2031				TRA-2031	-18 x
SR-1594				LG		1 REQD				2 REQD	1/2 LG FLAT PT

MANDREL ASSEMBLY  
2" WORK LENGTH

TOOL SIZE	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	ROLL (3) (4)	14 NO REQD
SR-1000	R-1000	SR-1000	SR-1000		
SR-1031	R-1031		SR-1031		SR-875
SR-1062	R-1062		SR-1062		
SR-1094	R-1094	SR-1031	SR-1094		
SR-1125	R-1031		SR-1125		
SR-1156	R-1062		SR-1156		
SR-1188	R-1094		SR-1188		
SR-1219	R-1219	SR-1188	SR-1219		
SR-1250	R-1250		SR-1250		
SR-1281	R-1281		SR-1281		
SR-1312	R-1312	SR-1312	SR-1312		7
SR-1344	R-1344		SR-1344		
SR-1375	R-1375		SR-1375		SR-1125
SR-1406	R-1406		SR-1406		
SR-1438	R-1438	SR-1375	SR-1438		
SR-1469	R-1469		SR-1469		
SR-1500	R-1500		SR-1500		
SR-1531	R-1531		SR-1531		
SR-1562	R-1562	SR-1562	SR-1562		
SR-1594	R-1594		SR-1594		

MANDREL ASSEMBLY  
4" WORK LENGTH

TOOL SIZE	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	ROLL (3) (4)	14 NO REQD
R-1000	SR-1000-4	SR-1000			
R-1031		SR-1031			SR-875
R-1062		SR-1062			
R-1094	SR-1031-4	SR-1094			
R-1031		SR-1125			
R-1062		SR-1156			
R-1094		SR-1188			
R-1219	SR-1188-4	SR-1219			
R-1250		SR-1250			
R-1281		SR-1281			
R-1312	SR-1312-4	SR-1312			7
R-1344		SR-1344			
R-1375		SR-1375			SR-1125
R-1406		SR-1406			
R-1438	SR-1375-4	SR-1438			
R-1469		SR-1469			
R-1500		SR-1500			
R-1531		SR-1531			
R-1562	SR-1562-4	SR-1562			
R-1594		SR-1594			

MANDREL ASSEMBLY  
6" WORK LENGTH

TOOL SIZE	11 MANDREL	12 SLEEVE (BUSHING REQD)	13 CAGE (1) (2)	ROLL (3) (4)	14 NO REQD
R-1000	SR-1000-6	SR-1000			
R-1031		SR-1031			SR-875
R-1062		SR-1062			
R-1094	SR-1031-6	SR-1094			
R-1031		SR-1125			
R-1062		SR-1156			
R-1094		SR-1188			
R-1219	SR-1188-6	SR-1219			
R-1250		SR-1250			
R-1281		SR-1281			
R-1312	SR-1312-6	SR-1312			7
R-1344		SR-1344			
R-1375		SR-1375			SR-1125
R-1406		SR-1406			
R-1438	SR-1375-6	SR-1438			
R-1469		SR-1469			
R-1500		SR-1500			
R-1531		SR-1531			
R-1562	SR-1562-6	SR-1562			
R-1594		SR-1594			

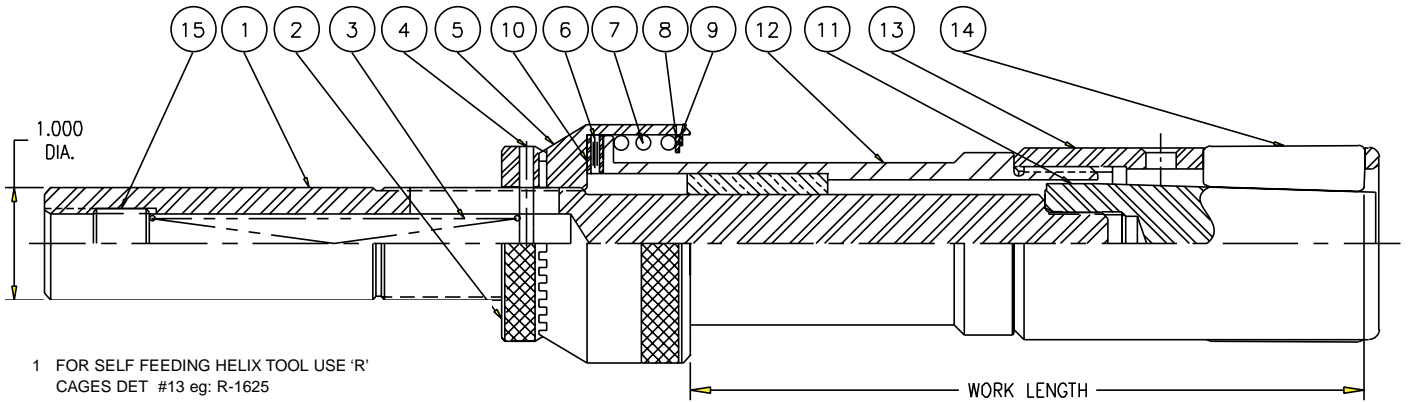
MANDREL ASSEMBLY  
8" WORK LENGTH

TOOL SIZE	11 MANDREL	12 SLEEVE (BUSHING REQD)	13 CAGE (1) (2)	ROLL (3) (4)	14 NO REQD
R-1000	SR-1000-8	SR-1000			
R-1031		SR-1031			SR-875
R-1062		SR-1062			
R-1094	SR-1031-8	SR-1094			
R-1031		SR-1125			
R-1062		SR-1156			
R-1094		SR-1188			
R-1219	SR-1188-8	SR-1219			
R-1250		SR-1250			
R-1281		SR-1281			
R-1312	SR-1312-8	SR-1312			7
R-1344		SR-1344			
R-1375		SR-1375			SR-1125
R-1406		SR-1406			
R-1438	SR-1375-8	SR-1438			
R-1469		SR-1469			
R-1500		SR-1500			
R-1531		SR-1531			
R-1562	SR-1562-8	SR-1562			
R-1594		SR-1594			

# Internal Roll-a-Finish® tools

# SR series

“SR-1625 ~ SR-1844” SERIES ROLL-A-FINISH® TOOLS 1-5/8 TO 1-7/8 IN. (41.28 TO 47.63mm)



- 1 FOR SELF FEEDING HELIX TOOL USE 'R' CAGES DET #13 eg: R-1625
- 2 FOR BOTTOMING TOOLS USE 'B' CAGES DET #13 eg: RB-1625
- 3 FOR SELF FEEDING HELIX TOOL USE 'R' ROLLS DET #14 eg: R-1625
- 4 FOR BOTTOMING TOOLS USE 'B' ROLLS DET #14 eg: RB-1625
- 5 FOR ALTERNATE WORK LENGTHS DESIGNATE SHANK DET #1 WITH -6 & -8

SR-1625 ADJUSTMENT ASSEMBLY

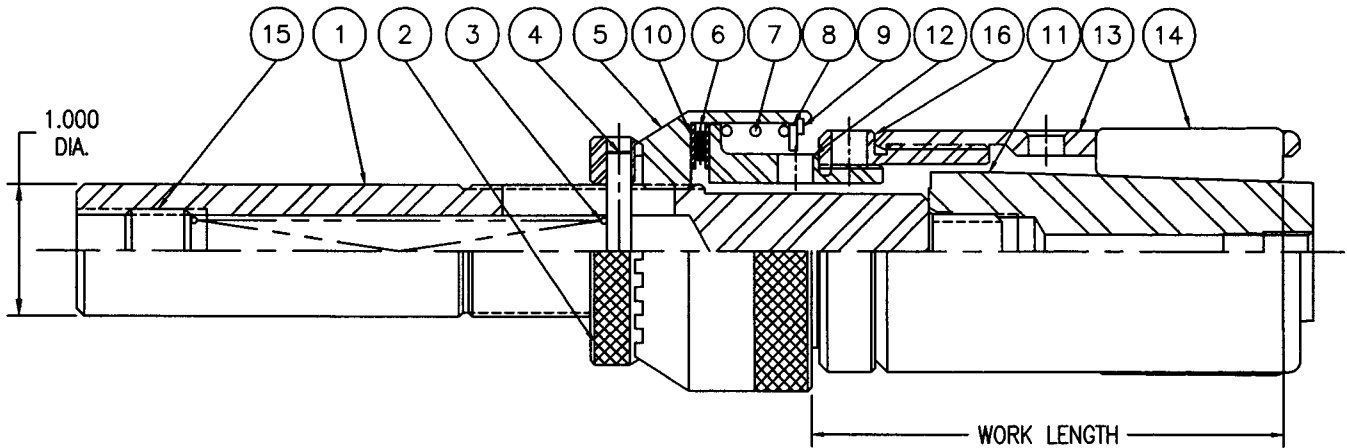
TOOL SIZE	1 SHANK (5)	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 * WASHER	9 SPIROLOX	10 THRUST RACE	15 SET SCREW
SR-1625											5/8
THRU	NRA-1625	RA-1000	RA-2000	RA-500	RA-1000	SR-1000	NRA-2500	SR-1000	SR-1000	CX-15 -D04	-11 x 1/2 LG FLAT PT
SR-1844						1 REQD				2 REQD	

TOOL SIZE	MANDREL ASSEMBLY 3.6" WORK LENGTH					MANDREL ASSEMBLY 6" WORK LENGTH					MANDREL ASSEMBLY 8" WORK LENGTH				
	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	12 SLEEVE (BUSHING REQ'D)	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	11 MANDREL	12 SLEEVE (BUSHING REQ'D)	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD
SR-1625	R-1625	NRA-1625	SR-1625	SR-1625	7	R-1625	NRA-1625-6	SR-1625	SR-1625	7	R-1625	NRA-1625-8	SR-1625	SR-1625	7
SR-1656	R-1656		SR-1656			R-1656		SR-1656			R-1656		SR-1656		
SR-1688	R-1688	NRA-1688	SR-1688			R-1688	SR-1688	R-1688			SR-1688				
SR-1719	R-1719		SR-1719			R-1719	SR-1719	R-1719			SR-1719				
SR-1750	R-1750		SR-1750			R-1750	SR-1750	R-1750			SR-1750				
SR-1781	R-1781		SR-1781			R-1781	SR-1781	R-1781			SR-1781				
SR-1812	R-1812	NRA-1812	SR-1812			R-1812	SR-1812	R-1812			SR-1812				
SR-1844	R-1844		SR-1844			R-1844	SR-1844	R-1844			SR-1844				

# SR series

# Internal Roll-a-Finish® tools

“SR-1875 ~ SR-2125” SERIES ROLL-A-FINISH® TOOLS 1-7/8 TO 2-5/32 IN. (47.63 TO 54.76mm)



- 1 FOR SELF FEEDING HELIX TOOL USE 'R' CAGES DET #13 eg: R-1875
- 2 FOR BOTTOMING TOOLS USE 'B' CAGES DET #13 eg: B-1875
- 3 FOR SELF FEEDING HELIX TOOL USE 'R' ROLLS DET #14 eg: R-1625
- 4 FOR BOTTOMING TOOLS USE 'B' ROLLS DET #14 eg: RB-1625
- 5 FOR ALTERNATE WORK LENGTHS DESIGNATE SHANK DET #1 WITH -6 & -8

SR-1625 ADJUSTMENT ASSEMBLY

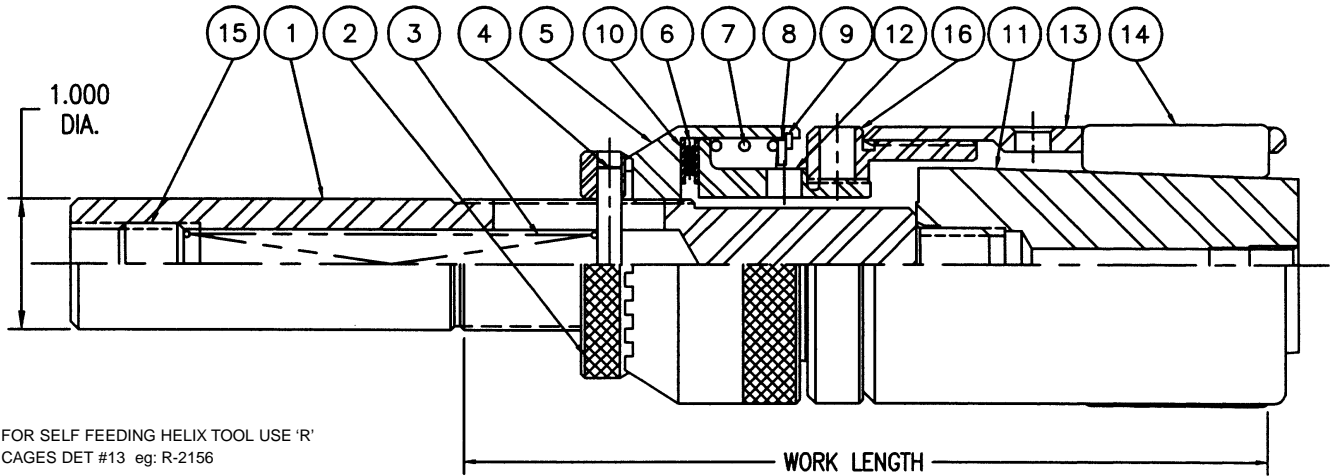
TOOL SIZE	1 SHANK (S)	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 WASHER	9 SPIROLOX	10 THRUST RACE	15 SET SCREW
SR-1875											5/8
THRU	NRA-1625	RA-1000	RA-2000	RA-500	RA-1000	SR-1000	NRA-2500	SR-1000	SR-1000	CX-15 -D04	-11 x 1/2 LG FLAT PT
SR-2125						1 REQD				2 REQD	

TOOL SIZE	MANDREL ASSEMBLY 3.6" WORK LENGTH					MANDREL ASSEMBLY 6" WORK LENGTH					MANDREL ASSEMBLY 8" WORK LENGTH							
	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	16 ADAPTOR	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	16 ADAPTOR (BUSHING REQD)	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	NO REQD	16 ADAPTOR (BUSHING REQD)
SR-1875	R-1875		SR-1875				R-1875		SR-1875				R-1875		SR-1875			
SR-1906	R-1906		SR-1906				R-1906		SR-1906				R-1906		SR-1906			
SR-1938	R-1938		SR-1938			NRA-1875	R-1938		SR-1938			NRA-1875-6	R-1938		SR-1938			NRA-1875-8
SR-1969	R-1969		SR-1969				R-1969		SR-1969				R-1969		SR-1969			
SR-2000	R-2000	NRA-1875	SR-2000	SR-1625	7		R-2000	NRA-1875	SR-2000	SR-1625	7		R-2000	NRA-1875	SR-2000	SR-1625	7	
SR-2031	R-2031		SR-2031				R-2031		SR-2031				R-2031		SR-2031			
SR-2062	R-2062		SR-2062			NRA-2000	R-2062		SR-2062			NRA-2000-6	R-2062		SR-2062			NRA-2000-8
SR-2094	R-2094		SR-2094				R-2094		SR-2094				R-2094		SR-2094			
SR-2125	R-2125		SR-2125				R-2125		SR-2125				R-2125		SR-2125			

# Internal Roll-a-Finish® tools

# SR series

“SR-2156 ~ SR-2500” SERIES ROLL-A-FINISH® TOOLS 2-5/32 TO 2-1/2 IN. (54.76 TO 63.5mm)



- 1 FOR SELF FEEDING HELIX TOOL USE 'R' CAGES DET #13 eg: R-2156
- 2 FOR BOTTOMING TOOLS USE 'B' CAGES DET #13 eg: RB-2156
- 3 FOR SELF FEEDING HELIX TOOL USE 'R' ROLLS DET #14 eg: R-1625
- 4 FOR BOTTOMING ROLLS USE 'B' ROLLS DET #14 eg: RB-1625
- 5 FOR -8 WORK LENGTH DESIGNATE SHANK DET #1 WITH -8

TOOL SIZE	SR-1625 ADJUSTMENT ASSEMBLY										
	1 SHANK (5)	2 LOCK RING	3 SPRING	4 ROLL PIN	5 COLLAR	6 THRUST BRG	7 SPRING	8 WASHER	9 SPIROLOX	10 THRUST RACE	15 SET SCREW
SR-2156											5/8
THRU SR-2500	NRA-1625	RA-1000	RA-2000	RA-500	RA-1000	SR-1000	NRA-2500	SR-1000	SR-10000	CX-15 -D04 2 REQD	-11 x 1/2 LG FLAT PT

TOOL SIZE	MANDREL ASSEMBLY 6" WORK LENGTH					
	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	16 ADAPTOR	
SR-2156	R-2156	NRA-1875	SR-2156	SR-1625	NRA-2000	
SR-2188	R-2188		SR-2188		7	NRA-2188
SR-2219	R-2219		SR-2219			
SR-2250	R-2250		SR-2250			
SR-2281	R-2281		SR-2281			
SR-2312	R-2312		SR-2312			
SR-2344	R-2344		SR-2344	9		
SR-2375	R-2375		SR-2375			
SR-2406	R-2406		SR-2406			
SR-2438	R-2438		SR-2438			
SR-2469	R-2469		SR-2469			
SR-2500	R-2500		SR-2500			NRA-2500-06

TOOL SIZE	MANDREL ASSEMBLY 8" WORK LENGTH				
	11 MANDREL	12 SLEEVE	13 CAGE (1) (2)	14 ROLL (3) (4)	16 ADAPTOR BUSHING REQD
R-2156	NRA-1875	SR-1625	SR-2156	7	NRA-2000-8
R-2188			SR-2188		
R-2219			SR-2219		
R-2250			SR-2250		
R-2281			SR-2281		
R-2312			SR-2312		
R-2344			SR-2344	9	NRA-2344-8
R-2375			SR-2375		
R-2406			SR-2406		
R-2438			SR-2438		
R-2469			SR-2469		
R-2500			SR-2500		

R series

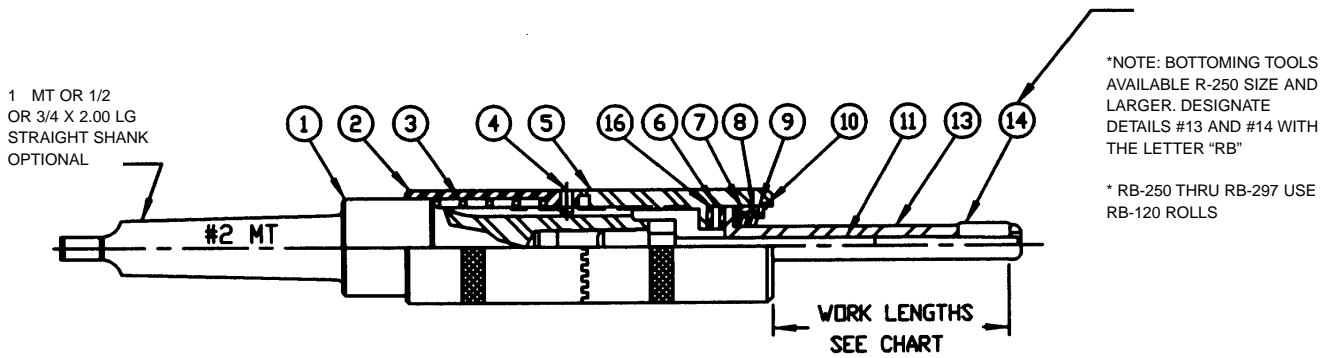
Internal Roll-a-Finish® tools



# R series

# Internal Roll-a-Finish® tools

“R-188 ~ R-484” SERIES ROLL-A-FINISH® TOOLS 3/16 TO 1/2 IN. (4.76 TO 12.7mm)

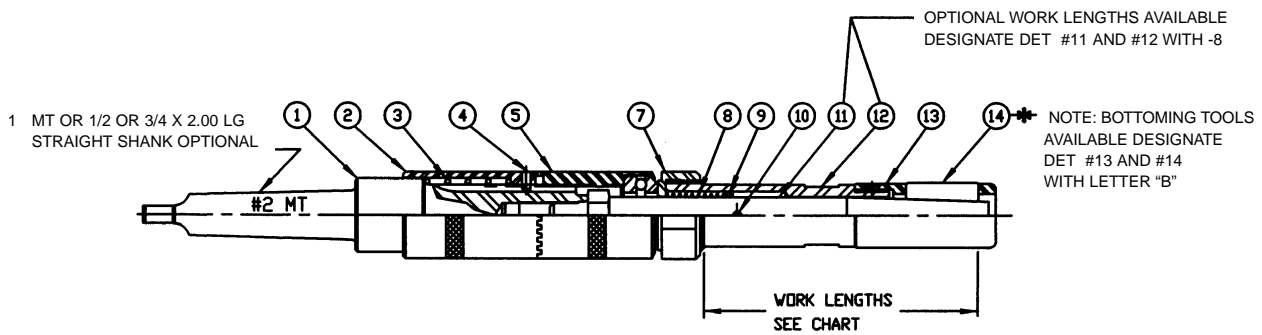


TOOL SIZE	R-188 ADJUSTMENT ASSEMBLY											MANDREL ASSEMBLY				WORK LENGTH
	1 SHANK	2 ADJ COLLAR	3 SPRING	4 SPIRO-L PIN	5 BRG COLLAR	6 THRUST BRG	7 SPACER	8 SPRING	9 SPRING RET	10 SPIRO-L OX	16 THRUST RACE	11 MANDREL	13* CAGE	14* ROLLS	14* NO. REQ'D	
R-188	R-500	R-1000	R-1000	R-01000	R-375	R-375	R-375	R-375	R-375	R-375	R-375	R-188	R-188	SR-187	3	2.62
R-195				-D04		2 REQ'D						R-195	R-195			
R-203												R-203	R-203			
R-211												R-211	R-211			
R-219												R-219	R-219			
R-226												R-226	R-226			
R-234												R-234	R-234			
R-242												R-242	R-242			
R-250												R-250	R-250	R-250	5	2.81
R-266												R-266	R-266			
R-281												R-281	R-281			
R-297												R-297	R-297			
R-312												R-312	R-312	R-312	5	
R-328												R-328	R-328			
R-344												R-344	R-344			
R-359												R-359	R-359			
R-375												R-375	R-375	R-375	5	
R-391												R-391	R-391			
R-406												R-406	R-406	R-437		
R-422												R-422	R-422			
R-438												R-438	R-438			
R-453												R-453	R-453			
R-469												R-469	R-469			
R-484												R-484	R-484			

# R series

# Internal Roll-a-Finish® tools

“R-500 ~ R-969” SERIES ROLL-A-FINISH® TOOLS 1/2 TO 1 IN. (12.7 TO 25.4mm)

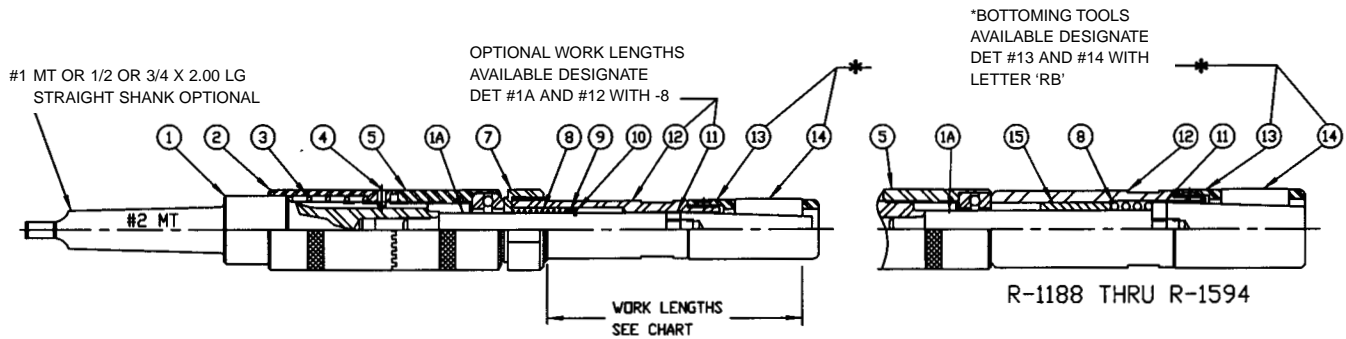


TOOL SIZE	R-500 ADJUSTMENT ASSEMBLY					MANDREL ASSEMBLY									WORK LENGTH	OPTIONAL WORK LGTH
	1 SHANK	2 ADJ COLLAR	3 SPRING	4 SPIROL PIN	5 BRG COLL ASSY	7 COLLAR	8 SPRING	9 SPRING RET	10 PIN	11 MANDREL	12 SLEEVE	13 * CAGE	14 * NO. ROLLS	NO. REQ'D		
R-500	R-500	R-1000	R-1000	R-01000	R1000	R-500	R-500	R-500	R-500	R-500	R-500	R-500	R-500	5	4.84	7.84
R-531				-D04		R-531	R-531	R-531	R-531	R-531	R-531	R-531	R-531			
R-562						R-562	R-562	R-562	R-562	R-562	R-562	R-562	R-562			
R-594						R-594	R-594	R-594	R-594	R-594	R-594	R-594	R-594			
R-625						R-625	R-625	R-625	R-625	R-625	R-625	R-625	R-625			
R-656						R-656	R-656	R-656	R-656	R-656	R-656	R-656	R-656			
R-688						R-688	R-688	R-688	R-688	R-688	R-688	R-688	R-688			
R-719						R-719	R-688	R-719	R-719	R-719	R-719	R-719	R-719			
R-750						R-750	R-656	R-750	R-750	R-750	R-750	R-750	R-750			
R-781						R-781	R-688	R-781	R-781	R-781	R-781	R-781	R-781			
R-812						R-812	R-688	R-812	R-812	R-812	R-812	R-812	R-812			
R-844						R-844	R-844	R-844	R-844	R-844	R-844	R-844	R-844			
R-875						R-875	R-688	R-875	R-875	R-875	R-875	R-875	R-875			
R-906						R-906	R-844	R-906	R-906	R-906	R-906	R-906	R-906			
R-938						R-938	R-844	R-938	R-938	R-938	R-938	R-938	R-938			
R-969						R-969	R-969	R-969	R-969	R-969	R-969	R-969	R-969			
													R-875	4.87	7.87	

# Internal Roll-a-Finish® tools

# R series

“R-1000 ~ R-1594” SERIES ROLL-A-FINISH® TOOLS 1 TO 1-5/8 IN. (25.4 TO 41.28mm)



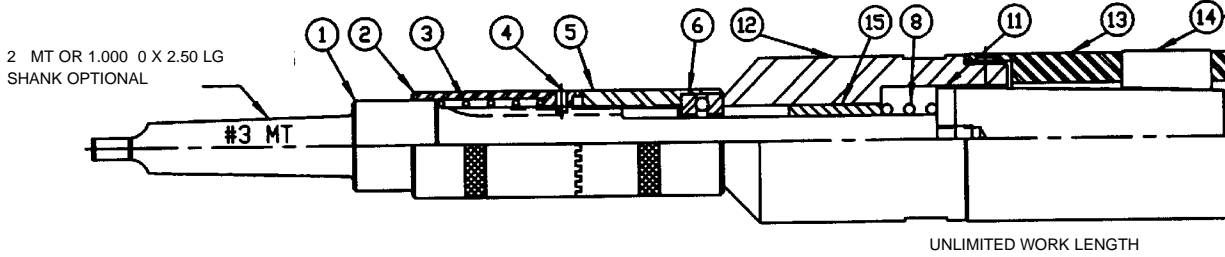
TOOL SIZE	R-1000 ADJUSTMENT ASSEMBLY									MANDREL ASSEMBLY								
	1 SHANK	1A SHANK EXT	2 ADJ COLLAR	3 SPRING	4 SPIROL PIN	5 BRG COLL ASSY	7 COLLAR	9 SPRING RET	10 SPIRO LDX	8 SPRING	11 MANDREL	12 SLEEVE	13 * CAGE	14 * ROLLS	15 BRZ BRG	WORK LENGTH	DPT WORK LGTH	
R-1000	R-500	R-1000	R-1000	R-1000	R-01000	R1000	R-1000	R-1000	R-1000	R-969	R-1000	R-1000	R-1000	R-875	7	NONE	4.87	7.87
R-1031					-D04				R-1031		R-1031	R-1031						
R-1062									R-1062			R-1062						
R-1094									R-1094			R-1094						
R-1125									R-1125			R-1125	R-1125					
R-1156									R-1156			R-1156						
R-1188							NONE	NONE	NONE		R-1188	R-1188	R-1188	R-1000 BRONZE BRG ASSEMBLED WITH DETAIL #12 SLEEVE		5.56	8.56	
R-1219									R-1219			R-1219						
R-1250									R-1250			R-1250						
R-1281									R-1281			R-1281						
R-1312									R-1312	R-1312	R-1312							
R-1344										R-1344	R-1344		UNLMTD WORK LGTH	NO OPTIONAL WORK LENGTH FOR THESE SIZES				
R-1375									R-1375	R-1375	R-1375							
R-1406									R-1406	R-1406	R-1406							
R-1438								R-1438		R-1438								
R-1469								R-1469		R-1469								
R-1500								R-1500		R-1500								
R-1531									R-1531	R-1531	R-1531							
R-1562									R-1562	R-1562	R-1562							
R-1594									R-1594	R-1594	R-1594							

# R series

# Internal Roll-a-Finish® tools

“R-1625 ~ R-2500” SERIES ROLL-A-FINISH® TOOLS 1-5/8 TO 2-1/2 IN. (41.28 TO 63.5mm)

BOTTOMING TOOLS  
AVAILABLE DESIG-  
NATE DET #13 AND  
#14 WITH LETTER 'B'



TOOL SIZE	R-2000 ADJUSTMENT ASSEMBLY						MANDREL ASSEMBLY							
	1 SHANK	2 ADJ COLLAR	3 SPRING	4 SPIROL PIN	5 BRG COLL	6 THRUST BRG	8 SPRING	11 MANDREL	12 SLEEVE	13 * CAGE	14 * ROLLS	15 NO. REQ'D	15 BRZ BRG	
R-1625	R-2000	R-2000	R-2000	R-01000	R-2000	INCLUDED WITH DETAIL #5 PRESSED IN	R-1625	R-1625	R-1625	R-1625	R-1625	7	R-2000	
R-1656				-D04			R-1656	R-1656	R-1656	R-1656				
R-1688							R-1688	R-1688	R-1688	R-1688				
R-1719								R-1719		R-1719				
R-1750								R-1750		R-1750				
R-1781								R-1781		R-1781				
R-1812								R-1812	R-1812	R-1812				
R-1844								R-1844		R-1844				
R-1875								R-1875	R-1875	R-1875				
R-1906								R-1906		R-1906				
R-1938								R-1938		R-1938				
R-1969								R-1969		R-1969				
R-2000								R-2000	R-2000	R-2000				
R-2031								R-2031		R-2031				
R-2062								R-2062		R-2062				
R-2094							R-2094		R-2094					
R-2125							R-2125		R-2125					
R-2156							R-2156		R-2156					
R-2188							R-2188	R-2188	R-2188					
R-2219							R-2219		R-2219					
R-2250							R-2250		R-2250					
R-2281							R-2281		R-2281					
R-2312							R-2312		R-2312					
R-2344							R-2344	R-2344	R-2344					
R-2375							R-2375		R-2375					
R-2406							R-2406		R-2406					
R-2438							R-2438		R-2438					
R-2469							R-2469		R-2469					
R-2500							R-2500	R-2500	R-2500					

Internal Roll-a-Finish® tools

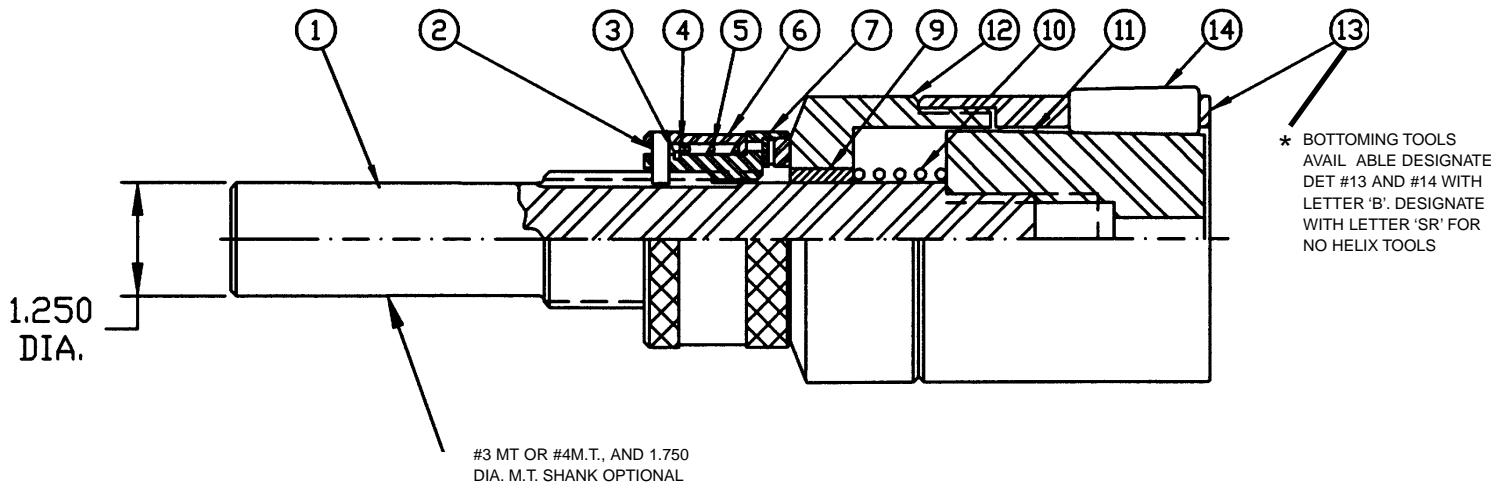
U series



# U series

# Internal Roll-a-Finish® tools

“U-2531 ~ U-3000” SERIES ROLL-A-FINISH® TOOLS 2-17/32 TO 3 IN. (64.3 TO 76.2mm)



U-3000 ADJUSTMENT ASSEMBLY

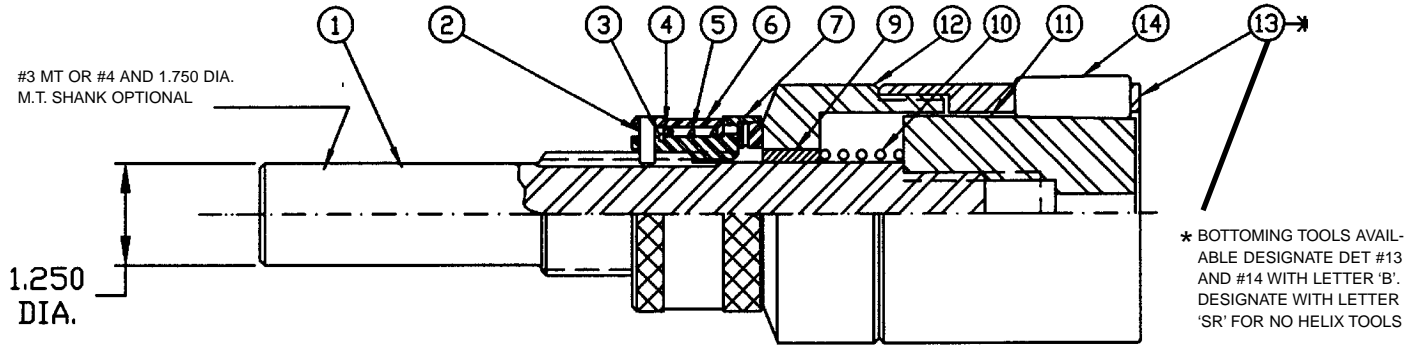
MANDREL ASSEMBLY

TOOL SIZE	1 SHANK	2 SPIROL PIN	3 SPIRO-LOX	4 WASHER	5 SPRING	6 ADJ COLLAR	7 BRG COLLAR ASSY	9 BUSHING	10 SPRING	11 MANDREL	12 SLEEVE	13 * CAGE	14 * ROLLS	NO. REQ'D	
U-2531	U-3000	U-3000	U-3000	U-3000	U-3000	U-3000	U-3000	BUSHING ASSEMBLED WITH DETAIL #12 SLEEVE	R-2531	R-2531	U-2531	R-2531	R-2531	9	
U-2562							DETAILS			R-2562					R-2562
U-2594										R-2594					R-2594
U-2625							7-A				R-2625	U-2625			R-2625
U-2656							U-3000				R-2656				R-2656
U-2688							BRG COLLAR				R-2688				R-2688
U-2719							7-B				R-2719				R-2719
U-2750							U-3000				R-2750	U-2750			R-2750
U-2781							THRUST PLATE				R-2781				R-2781
U-2812							7-C				R-2812				R-2812
U-2844							TDRR				R-2844				R-2844
U-2875							THRUST RACE			R-2875	R-2875	U-2875			R-2875
U-2906							TRB-2435				R-2906				R-2906
U-2938							7-D				R-2938				R-2938
U-2969							TDRR			R-2969		R-2969			
U-3000							THRUST BRG			R-3000	U-3000	R-3000	R-5000		
							NTA-2435								

# Internal Roll-a-Finish® tools

# U series

“U-3031 ~ U-3500” SERIES ROLL-A-FINISH® TOOLS 3-1/32 TO 3-1/2 IN. (76.98 TO 88.9mm)

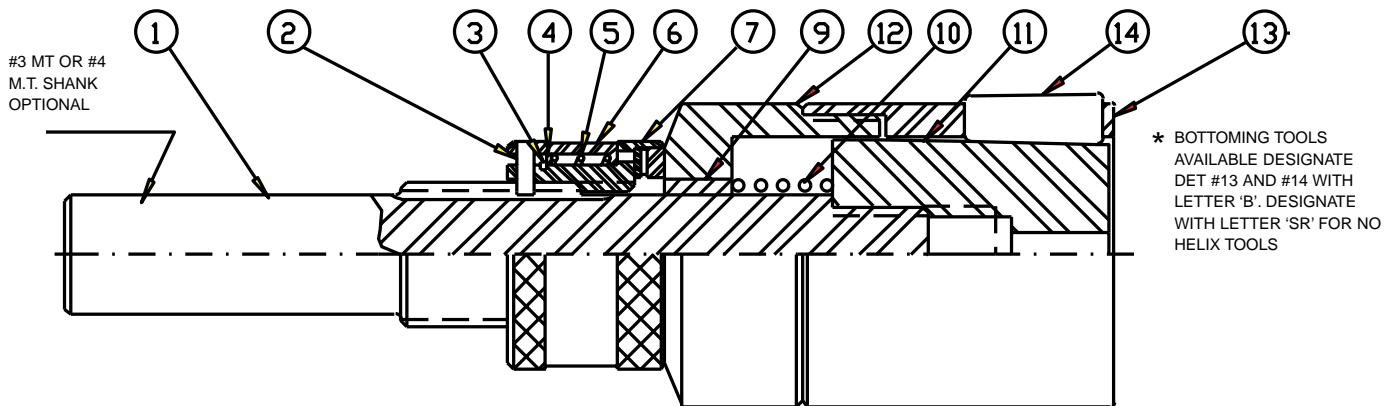


TOOL SIZE	1 SHANK	2 SPIROL PIN	3 SPIRO-LOX	4 WASHER	5 SPRING	6 ADJ COLLAR	7 BRG COLLAR ASSY	9 BUSHING	10 SPRING	11 MANDREL	12 SLEEVE	13 * CAGE	14 * ROLLS	NO. REQ'D
U-3031	U-3000	U-3000	U-3000	U-3000	U-3000	U-3000	U-3000	BUSHING ASSEMBLED WITH DETAIL #12 SLEEVE	R-2875	R-3031	U-3000	R-3031	R-5000	9
U-3062							DETAILS			R-3062		R-3062		
U-3094							7-A			R-3094		R-3094		
U-3125							U-3000			R-3125	U-3125	R-3125		
U-3156							BRG COLLAR			R-3156		R-3156		
U-3188							7-B			R-3188		R-3188		
U-3219							U-3000			R-3219		R-3219		
U-3250							THRUST PLATE			R-3250	U-3250	R-3250		
U-3281							7-C			R-3281		R-3281		
U-3312							TORR			R-3312		R-3312		
U-3344							THRUST RACE			R-3344		R-3344		
U-3375							TRB-2435			R-3375	U-3375	R-3375		
U-3406							7-D			R-3406		R-3406		
U-3438							TORR			R-3438		R-3438		
U-3469							THRUST BRG			R-3469		R-3469		
U-3500							NTA-2435	R-3500	U-3500	R-3500				

# U series

# Internal Roll-a-Finish® tools

“U-3531 ~ U-4000” SERIES ROLL-A-FINISH® TOOLS 3-17/32 TO 4 IN. (89.68 TO 101.6mm)



U-3000 ADJUSTMENT ASSEMBLY      MANDREL ASSEMBLY

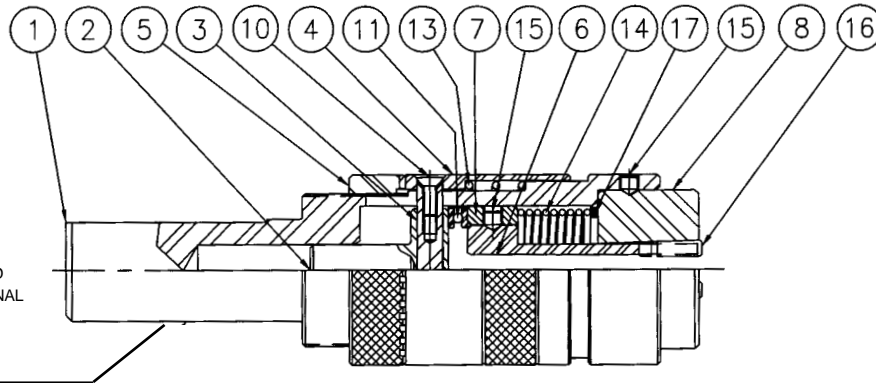
TOOL SIZE	1 SHANK	2 SPIROL PIN	3 SPIROLOX	4 WASHER	5 SPRING	6 ADJ COLLAR	7 BRG COLLAR ASSY	9 BUSHING	10 SPRING	11 MANDREL	12 SLEEVE	13 * CAGE	14 * ROLLS	NO REQ'D	
U-3531	U-3000	3/16	RS-187	U-3000	U-3000	U-3000	U-3000	ALTER BUNTING P-125-5	R-3500	R-3531	U-3500	R-3531	R-5000	9	
U-3562		DIA. X					DETAILS			R-3562		R-3562			
U-3594		5/8 LG								R-3594		R-3594			
U-3625		M-B-K							R-3625	R-3625	U-3625	R-3625			
U-3656							7-A			R-3656		R-3656			
U-3688							U-3000 BRG COLLAR 7-B			R-3688		R-3688			
U-3719							U-3000 THRUST PLATE 7-C			R-3719		R-3719			
U-3750							TDRR			R-3750	U-3750	R-3750			
U-3781							THRUST RACE			R-3781		R-3781			
U-3812							TRB-2435			R-3812		R-3812			
U-3844							7-D		R-3844		R-3844				
U-3875							TDRR		R-3875	U-3875	R-3875				
U-3906							THRUST BRG		R-3906		R-3906				
U-3938							NTA-2435		R-3938		R-3938				
U-3969									R-3969		R-3969				
U-4000									R-4000	U-4000	R-4000		11		



# AEX series

# External Roll-a-Finish® tools

“AEX-1 0.062 ~ 0.484” SERIES ROLL-A-FINISH® TOOLS 1/16 TO 31/64 IN. (1.57 TO 12.29mm)



1.000" DIA. SHANK STANDARD  
 3/4 DIA. AND 1" ACME OPTIONAL  
 NOTE:  
 AEX-1" ACME SHANK  
 REQUIRES DETAIL #9 LOCK  
 NUT (AEX-A-D19)

AEX-1 ADJUSTMENT ASSEMBLY

TOOL SIZE	1 SHANK	2 STOP	3 ADJ PIN	4 ADJ COLLAR	5 LOCKING RING	10 FLAT HD. SCREW	11 THRUST BRG	13 SPRING	15 SOC SET SCREW
AEX-1-062 THRU AEX-1-484	AEX-1	AEX-1	AEX-1	AEX-1	AEX-1	#6-32 x 3/8 LG 2 REQD	AEX-1	AEX-1	#10-32 x 3/16LG CONE PT 3 REQ'D

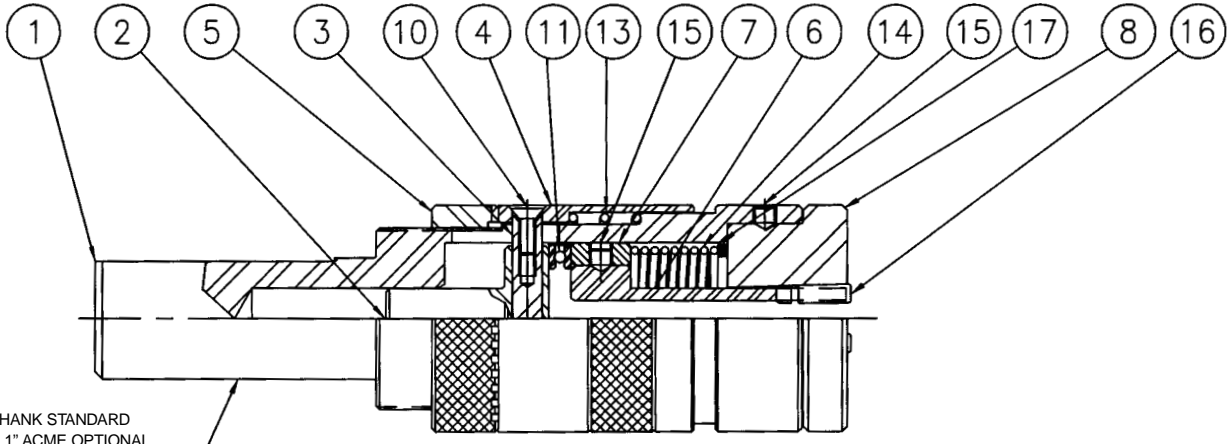
RACE ASSEMBLY

TOOL SIZE	7 CAGE RETAINER	14 SPRING	15 SOC SET SCREW	17 WASHER	8 RACE	6 CAGE	ROLL	16 NO REQD
AEX-1-062	AEX-1	E2-D09	#10-32 x 3/16LG CONE PT 3 REQ'D	E2-D15	AE-062	AE-062	B-500	3
AEX-1-078					AE-078	AE-078		
AEX-1-094					AE-094	AE-094		
AEX-1-109					AE-109	AE-109		
AEX-1-125					AE-125	AE-125		
AEX-1-141					AE-141	AE-141		
AEX-1-156					AE-156	AE-156		
AEX-1-171					AE-171	AE-171		
AEX-1-187					AE-187	AE-187		
AEX-1-203					AE-203	AE-203		
AEX-1-219					AE-219	AE-219		
AEX-1-234					AE-234	AE-234		
AEX-1-250					AE-250	AE-250		
AEX-1-266					AE-266	AE-266		
AEX-1-281					AE-281	AE-281		
AEX-1-297					AE-297	AE-297		
AEX-1-312					AE-312	AE-312		
AEX-1-328					AE-328	AE-328		
AEX-1-344					AE-344	AE-344		
AEX-1-359					AE-359	AE-359		
AEX-1-375					AE-375	AE-375		
AEX-1-391					AE-391	AE-391	B-750	5
AEX-1-406					AE-406	AE-406		
AEX-1-422					AE-422	AE-422		
AEX-1-438					AE-438	AE-438		
AEX-1-453					AE-453	AE-453		
AEX-1-469					AE-469	AE-469		
AEX-1-484					AE-484	AE-484		

# External Roll-a-Finish® tools

# AEX series

“AEX-1 0.500 ~ 0.625” SERIES ROLL-A-FINISH® TOOLS 1/2 TO 5/8 IN. (12.7 TO 15.88mm)



1.000" DIA. SHANK STANDARD  
3/4 DIA. AND 1" ACME OPTIONAL

NOTE:  
AEX-1" ACME SHANK  
REQUIRES DETAIL #9 LOCK  
NUT (AEX-A-D19)

### AEX-1 ADJUSTMENT ASSEMBLY

TOOL SIZE	1 SHANK	2 STOP	3 ADJ PIN	4 ADJ COLLAR	5 LOCKING RING	10 FLAT HD. SCREW	11 THRUST BRG	13 SPRING	15 SOC SET SCREW
AEX-1-500 THRU AEX-1-625	AEX-1	AEX-1	AEX-1	AEX-1	AEX-1	#6-32 x 3/8 LG 2 REQD	AEX-1	AEX-1	#10-32 x 3/16LG CONE PT 3 REQ'D

### RACE ASSEMBLY

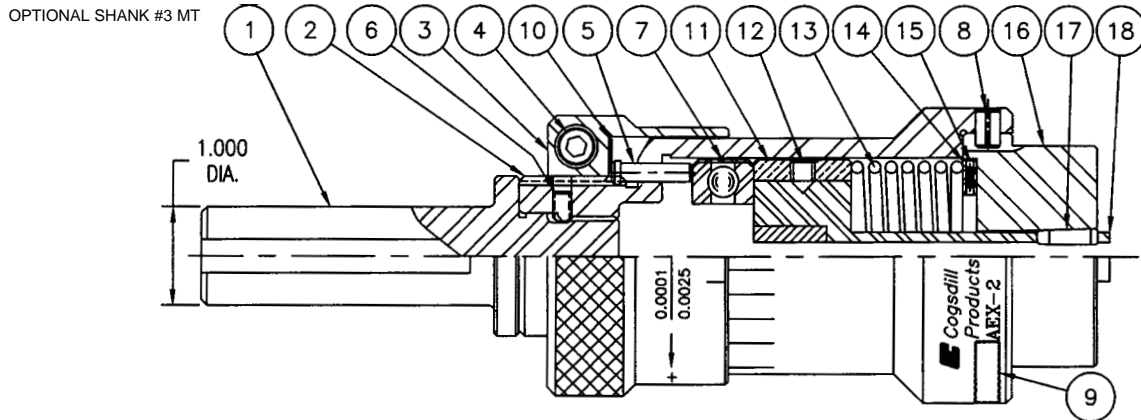
TOOL SIZE	7 CAGE RETAINER	14 SPRING	15 SOC SET SCREW	17 WASHER	8 RACE	6 CAGE	16 ROLL	NO REQD
AEX-1-500	AEX-1	E2-D09	#10-32 x 3/16LG CONE PT 3 REQ'D	E2-D15	AE-500	AE-500	B-750	5
AEX-1-516					AE-516	AE-516		
AEX-1-531					AE-531	AE-531		
AEX-1-547					AE-547	AE-547		
AEX-1-562					AE-562	AE-562		
AEX-1-578					AE-578	AE-578		
AEX-1-594					AE-594	AE-594		
AEX-1-609					AE-609	AE-609		
AEX-1-625					AE-625	AE-625		

Note: Standard Tool Has A Bottoming-Style (No Helix) Cage

# AEX series

# External Roll-a-Finish® tools

“AEX-2 0.062 ~ 0.375” SERIES ROLL-A-FINISH® TOOLS 1/16 TO 3/8 IN. (1.57 TO 9.53mm)



\* FOR BOTTOMING TOOLS  
DESIGNATE TOOL WITH 'B'  
eg: AEXB-2-062  
DESIGNATE CAGE DET #18  
WITH 'B' eg: NEB-062  
USE B-500 DET #17 ROLLS

AEX-2 ADJUSTMENT ASSEMBLY

TOOL SIZE *	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 WASHER
AEX-2-062	AEX-2	AEX-2	AEX-2	x 7/8	AEX-2	AEX-2	E-3-D05	AEX-2	AEX-2	AEX-2
THRU AEX-2-375					3 REQD				3 REQD	

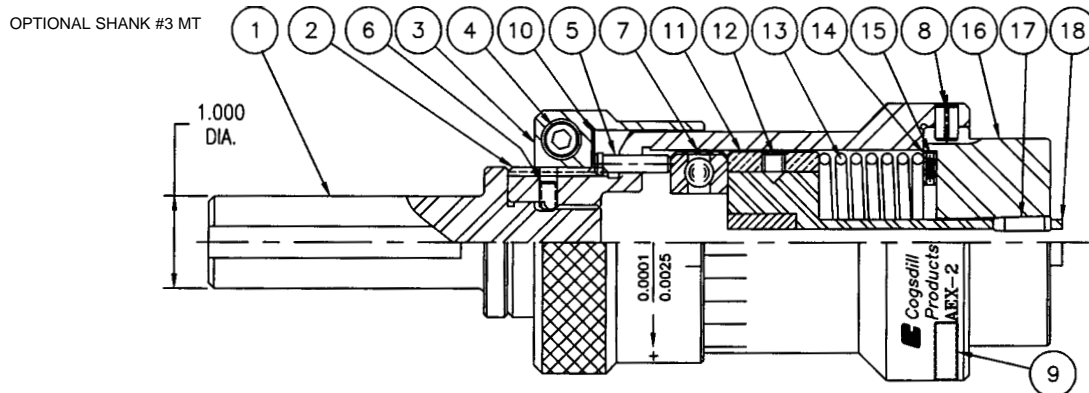
RACE ASSEMBLY

TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 THRUST RACE	15 THRUST BEARING	16 RACE	18 CAGE *	ROLL *	17 NO REQD
AEX-2-062						CX-062	NE-062		
AEX-2-078						CX-078	NE-078		
AEX-2-094						CX-094	NE-094		
AEX-2-109						CX-109	NE-109		
AEX-2-125						CX-125	NE-125		
AEX-2-141						CX-141	NE-141		
AEX-2-156						CX-156	NE-156		3
AEX-2-171						CX-171	NE-171		
AEX-2-187						CX-187	NE-187		
AEX-2-203						CX-203	NE-203		
AEX-2-219	E-3-D06	AEX-2	EX-1-D10	CX-15-D04	SR-1000	CX-219	NE-219	SR-500	
AEX-2-234		3 REQ'D		2 REQ'D	-D06	CX-234	NE-234		
AEX-2-250						CX-250	NE-250		
AEX-2-266						CX-266	NE-266		
AEX-2-281						CX-281	NE-281		
AEX-2-297						CX-297	NE-297		
AEX-2-312						CX-312	NE-312		5
AEX-2-328						CX-328	NE-328		
AEX-2-344						CX-344	NE-344		
AEX-2-359						CX-359	NE-359		
AEX-2-375						CX-375	NE-375		

# External Roll-a-Finish® tools

# AEX series

“AEX-2 0.391 ~ 0.750” SERIES ROLL-A-FINISH® TOOLS 25/64 TO 3/4 IN. (9.93 TO 19.05mm)



\* FOR BOTTOMING TOOLS  
 DESIGNATE TOOL WITH 'B'  
 eg: AEXB-2-391  
 DESIGNATE CAGE DET. #18  
 WITH 'B' eg: NEB-391  
 USE B-750 DET #17 ROLLS

AEX-2 ADJUSTMENT ASSEMBLY

TOOL SIZE *	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 WASHER
AEX-2-391										
THRU	AEX-2	AEX-2	AEX-2	AEX-2	AEX-2	AEX-2	E-3-D05	AEX-2	AEX-2	AEX-2
AEX-2-750					AEX-2 3 REQD				AEX-2 3 REQD	

RACE ASSEMBLY

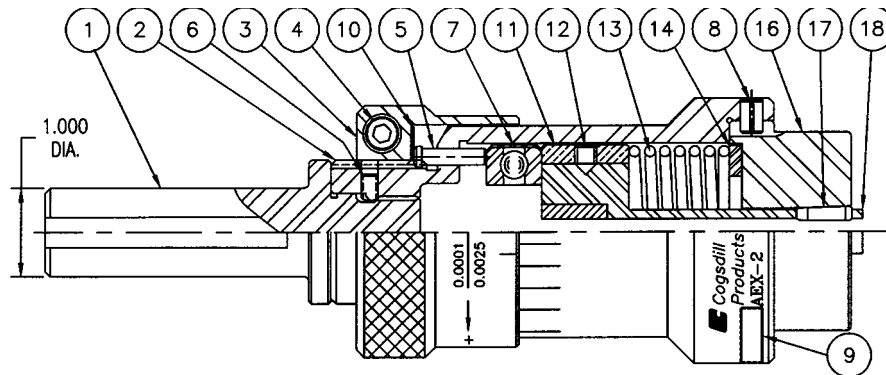
TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 THRUST RACE	15 THRUST BEARING	16 RACE	18 CAGE *	17 ROLL *	NO REQD
AEX-2-391						CX-391	NE-391		
AEX-2-406						CX-406	NE-406		
AEX-2-422						CX-422	NE-422		
AEX-2-438						CX-438	NE-438		
AEX-2-453						CX-453	NE-453		
AEX-2-469						CX-469	NE-469		
AEX-2-484						CX-484	NE-484		
AEX-2-500						CX-500	NE-500		
AEX-2-516						CX-516	NE-516		
AEX-2-531						CX-531	NE-531		
AEX-2-547						CX-547	NE-547		
AEX-2-562	E-3-D06	AEX-2	EX-1-D10	CX-15-D04	SR-1000	CX-562	NE-562	SR-750	5
AEX-2-578		3 REQ'D		2 REQ'D	-D06	CX-578	NE-578		
AEX-2-594						CX-594	NE-594		
AEX-2-609						CX-609	NE-609		
AEX-2-625						CX-625	NE-625		
AEX-2-641						CX-641	NE-641		
AEX-2-656						CX-656	NE-656		
AEX-2-672						CX-672	NE-672		
AEX-2-688						CX-688	NE-688		
AEX-2-703						CX-703	NE-703		
AEX-2-719						CX-719	NE-719		
AEX-2-734						CX-734	NE-734		
AEX-2-750						CX-750	NE-750		

Note: Standard Tool Has A Machine-Feeding (No Helix) Or Bottoming-Style (No Helix) Cage

# AEX series

# External Roll-a-Finish® tools

“AEX-2 0.766 ~ 1.000” SERIES ROLL-A-FINISH® TOOLS 49/64 TO 1 IN. (19.46 TO 25.4mm)



AEX-2 ADJUSTMENT ASSEMBLY

TOOL SIZE *	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 WASHER
AEX-2-766 THRU AEX-2-1000	AEX-2	AEX-2	AEX-2	1/4-20 x 7/8 LG	AEX-2 3 REQD	#10-24 x 1/4 LG OVAL PT 1 REQD	D-10	1/4 DIA x 3/8 LG	#10-32 x 1/4 LG CONE PT 3 REQD	AEX-2

\* FOR BOTTOMING TOOLS  
DESIGNATE TOOL WITH 'B'  
eg: AEXB-2-766  
DESIGNATE CAGE DET #18  
WITH 'B' eg: NEB-766  
USE SR-875 DET #17 ROLLS  
eg: RB-875

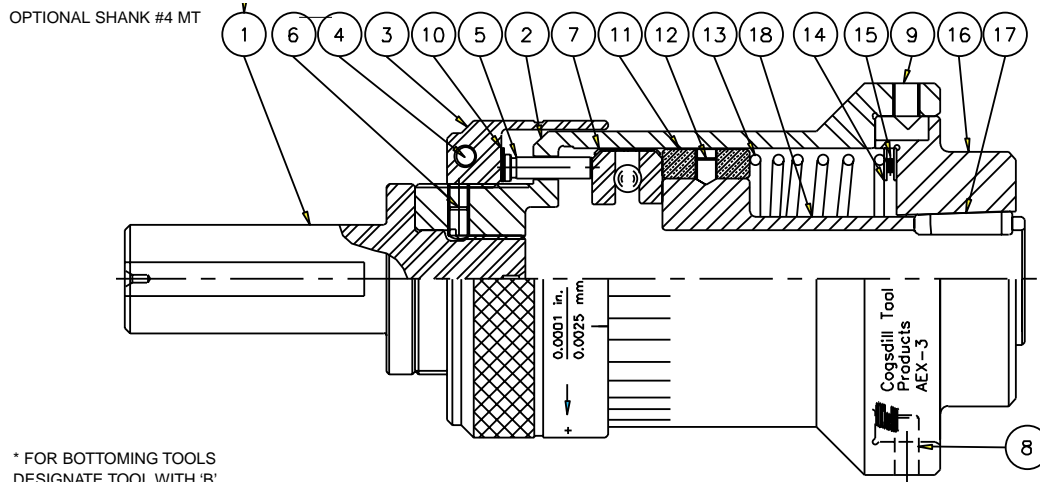
RACE ASSEMBLY

TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 SPACER	16 RACE	18 CAGE *	17 ROLL *	NO REQD
AEX-2-766	E-3	1/4-28 x 1/4 LG CONE PT 3 REQ'D	EX-1	E-3-D15	CX-766	NE-766	SR-875	5
AEX-2-781					CX-781	NE-781		
AEX-2-797					CX-797	NE-797		
AEX-2-812					CX-812	NE-812		
AEX-2-828					CX-828	NE-828		
AEX-2-844					CX-844	NE-844		
AEX-2-859					CX-859	NE-859		
AEX-2-875					CX-875	NE-875		
AEX-2-891					CX-891	NE-891		
AEX-2-906					CX-906	NE-906		
AEX-2-922					CX-922	NE-922		
AEX-2-938					CX-938	NE-938		
AEX-2-953					CX-953	NE-953		
AEX-2-969					CX-969	NE-969		
AEX-2-984					CX-984	NE-984		
AEX-2-1000					CX-1000	NE-1000		

# External Roll-a-Finish® tools

# AEX series

“AEX-3 1.016 ~ 1.250” SERIES ROLL-A-FINISH® TOOLS 1-1/64 TO 1-1/4 IN. (25.81 TO 31.75mm)



\* FOR BOTTOMING TOOLS  
 DESIGNATE TOOL WITH 'B'  
 eg: AEXB-1016  
 DESIGNATE CAGE DE #18  
 WITH 'B' eg: AEXB-1016  
 USE B-875 DET #17 ROLLS  
 eg: RB-875

AEX-3 ADJUSTMENT ASSEMBLY

TOOL SIZE *	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 THRUST RACE
AEX-1016	AEX-3	AEX-3	AEX-3	1/4-20 x 7/8 LG	AEX-3 3 REQD	1/4-28 x 3/8 LG OVAL PT 1 REQD	D-20	1/4 DIA x 5/8 LG	1/4-28 x 3/8 LG CONE PT 3 REQD	TORR TRA-3648
AEX-1250										

RACE ASSEMBLY

TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 THRUST RACE	15 THRUST BEARING	16 RACE	18 CAGE *	17 ROLL *	NO REQD
AEX-1016	AEX-3	5/16-18 x 3/8 LG CONE PT 3 REQ'D	R-5000-3	TORR TRA-3648 2 REQ'D	TORR NTA-3648	AEX-1016	AEXNE-1016	SR-875	5
AEX-1031						AEXNE-1031			
AEX-1047						AEXNE-1047			
AEX-1062						AEXNE-1062			
AEX-1078						AEXNE-1078			
AEX-1094						AEXNE-1094			
AEX-1109						AEXNE-1109			
AEX-1125						AEXNE-1125			
AEX-1141						AEXNE-1141			
AEX-1156						AEXNE-1156			
AEX-1172						AEXNE-1172			
AEX-1188						AEXNE-1188			
AEX-1203						AEXNE-1203			
AEX-1219						AEXNE-1219			
AEX-1234						AEXNE-1234			
AEX-1250						AEXNE-1250			

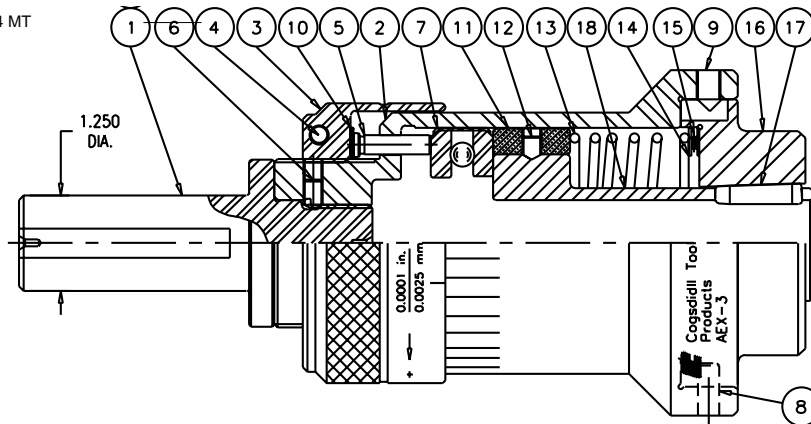
Note: Standard Tool Has A Machine-Feeding (No-Helix) Or Bottoming-Style (No Helix) Cage

# AEX series

# Internal Roll-a-Finish® tools

“AEX-3 1.266~ 1.625” SERIES ROLL-A-FINISH® TOOLS 1-17/64 TO 1-5/8 IN. (32.16 TO 41.28mm)

OPTIONAL SHANK #4 MT



\* FOR BOTTOMING TOOLS  
 DESIGNATE TOOL WITH 'B'  
 eg: AEXB-1266  
 DESIGNATE CAGE DET #18  
 WITH 'B' eg: AEXB-1266  
 USE B-1125 DET #17 ROLLS  
 eg: RB-1125

### AEX-3 ADJUSTMENT ASSEMBLY

TOOL SIZE *	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 THRUST RACE
AEX-1266	AEX-3	AEX-3	AEX-3	1/4-20 x 7/8 LG	AEX-3 3 REQD	1/4-28 x 3/8 LG OVAL PT 1 REQD	D-20	1/4 DIA x 5/8 LG	5/16-18 x 3/8 LG CONE PT 3 REQD	TORR TRA- 3648
AEX-1625										

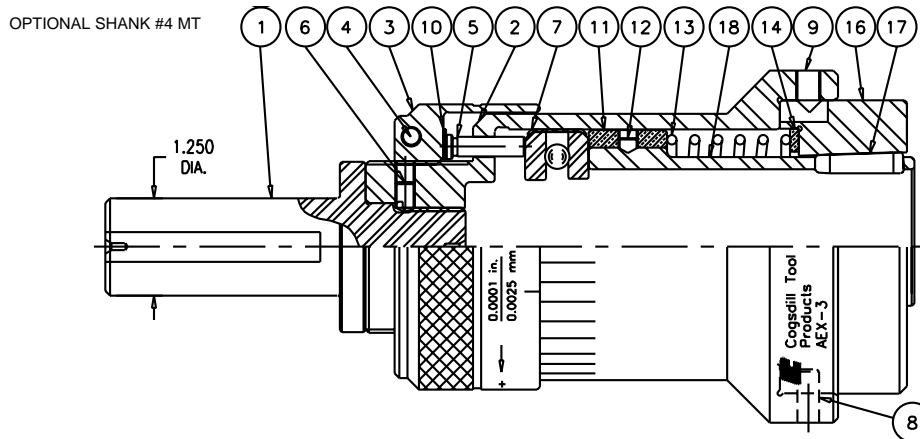
### RACE ASSEMBLY

TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 THRUST RACE	15 THRUST BEARING	16 RACE	18 CAGE *	ROLL *	17 NO REQD
AEX-3-1266	AEX-3	1/4-28 x 3/8 LG CONE PT 3 REQ'D	R- 5000-3	AEX-3 2 REQ'D	SR-02000	AEX-1266	AEX-1266	SR-1125	7
AEX-3-1281						AEX-1281			
AEX-3-1297						AEX-1297			
AEX-3-1312						AEX-1312			
AEX-3-1328						AEX-1328			
AEX-3-1344						AEX-1344			
AEX-3-1359						AEX-1359			
AEX-3-1375						AEX-1375			
AEX-3-1391						AEX-1391			
AEX-3-1406						AEX-1406			
AEX-3-1422						AEX-1422			
AEX-3-1438						AEX-1438			
AEX-3-1453						AEX-1453			
AEX-3-1469						AEX-1469			
AEX-3-1484						AEX-1484			
AEX-3-1500						AEX-1500			
AEX-3-1516						AEX-1516			
AEX-3-1531						AEX-1531			
AEX-3-1547						AEX-1547			
AEX-3-1562						AEX-1562			
AEX-3-1578						AEX-1578			
AEX-3-1594	AEX-1594								
AEX-3-1609	AEX-1609								
AEX-3-1625	AEX-1625								

# Internal Roll-a-Finish® tools

# AEX series

“AEX-3 1.641 ~ 2.000” SERIES ROLL-A-FINISH® TOOLS 1-41/64 TO 2 IN. (41.68 TO 50.8mm)



AEX-3 ADJUSTMENT ASSEMBLY

TOOL SIZE #	1 SHANK	2 HOUSING	3 ADJ RING	4 CAP SCREW	5 PIN	6 SOC SET SCREW	7 THRUST BEARING	8 SPIROL PIN	9 SOC SET SCREW	10 THRUST RACE
AEX-1641 THRU AEX-2000	AEX-3	AEX-3	AEX-3	1/4-20 x 7/8 LG	AEX-3 3 REQD	1/4-28 x 3/8 LG OVAL PT 1 REQD	D-20	1/4 DIA x 5/8 LG	5/16-18 x 3/8 LG CONE PT 3 REQD	TORR TRA- 3648

RACE ASSEMBLY

TOOL SIZE	11 CAGE RETAINER	12 SOC SET SCREW	13 SPRING	14 WASHER	16 RACE	18 CAGE #	17 ROLL #	NO REQD
AEX-3-1641	AEX-3	1/4-28 x 3/8 LG CONE PT 3 REQ'D	R- 5000-3	AEX-3	AEX-1641	AEXNE-1641	SR-1125	7
AEX-3-1656					AEX-1656	AEXNE-1656		
AEX-3-1672					AEX-1672	AEXNE-1672		
AEX-3-1688					AEX-1688	AEXNE-1688		
AEX-3-1703					AEX-1703	AEXNE-1703		
AEX-3-1719					AEX-1719	AEXNE-1719		
AEX-3-1734					AEX-1734	AEXNE-1734		
AEX-3-1750					AEX-1750	AEXNE-1750		
AEX-3-1766					AEX-1766	AEXNE-1766		
AEX-3-1781					AEX-1781	AEXNE-1781		
AEX-3-1797					AEX-1797	AEXNE-1797		
AEX-3-1812					AEX-1812	AEXNE-1812		
AEX-3-1828					AEX-1828	AEXNE-1828		
AEX-3-1844					AEX-1844	AEXNE-1844		
AEX-3-1859					AEX-1859	AEXNE-1859		
AEX-3-1875					AEX-1875	AEXNE-1875		
AEX-3-1891					AEX-1891	AEXNE-1891		
AEX-3-1906					AEX-1906	AEXNE-1906		
AEX-3-1922					AEX-1922	AEXNE-1922		
AEX-3-1938					AEX-1938	AEXNE-1938		
AEX-3-1953	AEX-1953	AEXNE-1953						
AEX-3-1969	AEX-1969	AEXNE-1969						
AEX-3-1984	AEX-1984	AEXNE-1984						
AEX-3-2000	AEX-2000	AEXNE-2000						

\* FOR BOTTOMING TOOLS  
DESIGNATE TOOL WITH 'B'  
eg: AEXB-1641  
DESIGNATE CAGE DET #18  
WITH 'B' eg: AEXB-1641  
USE B-1125 DET #17 ROLLS  
eg: RB-1125

Note: Standard Tool Has A Machine-Feeding (No-Helix) Or Bottoming-Style (No Helix) Cage

## Other Cogsdill burnishing products

In addition to Roll-a-Finish tools for IDs, ODs, and special part configurations, Cogsdill offers several other burnishing products and related items, including:

- *Bearingizing Tools*, for burnishing IDs in parts with thin walls or irregular wall thicknesses, or in applications where porosity retention or extremely close tolerances are required
- *CX® External Roller Burnishing Machines*, for sizing, finishing, and work-hardening cylindrical surfaces of any length
- *Diamond Burnishing Tools*, for generating mirror finishes on ODs, large IDs, or faces of virtually any diameter
- *Universal Burnishing Tools*, for burnishing ODs, large IDs, faces, tapers, contours, and irregular surfaces with a single roll
- *The KB Knurling-Burnishing Process*, for salvaging out-of-tolerance bores and shafts: a two-step process using Cogsdill knurling tools and Roll-a-Finish tools

***Request Our Full Catalog On  
Burnishing Tools & Machines***

CX  
external roller burnishing machines

burnishing tools

diamond

KB  
Knurling-Burnishing Process

universal  
burnishing  
tools

bearingizing  
tools

# Notes

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**FOR ADDITIONAL INFORMATION**

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