
















Advanced  
Metalworking  
with 3M support






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## Product symbols

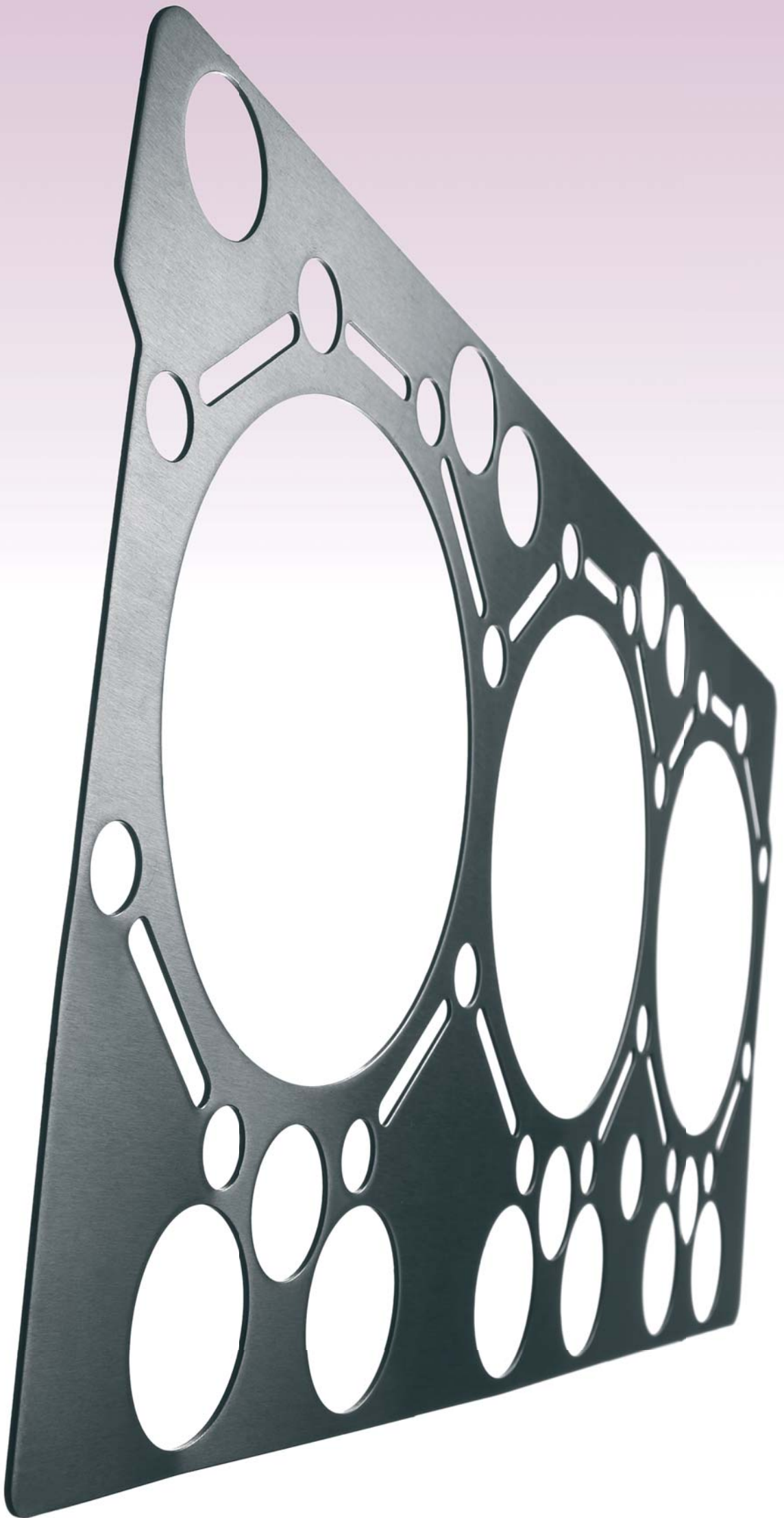
 <b>SS</b>	Stainless Steel	 <b>GA</b>	Grinding Aid
 <b>MS</b>	Mild Steel	 <b>H</b>	High Pressure
 <b>AL</b>	Aluminium	 <b>M</b>	Medium Pressure
 <b>AZ</b>	Alumina Zirconia	 <b>L</b>	Low Pressure
 <b>AO</b>	Aluminium Oxide	 <b>TIG</b>	TIG Weld
 <b>CU</b>	3M™ Cubitron™ Mineral	 <b>MIG</b>	MIG Weld
 <b>SiC</b>	Silicon Carbide	 <b>H&amp;S</b>	Health and Safety Solution
 <b>3M Best Performer</b> ✓	3M's recommendation for best performance under optimum conditions where value can be measured		

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## Safety Icons

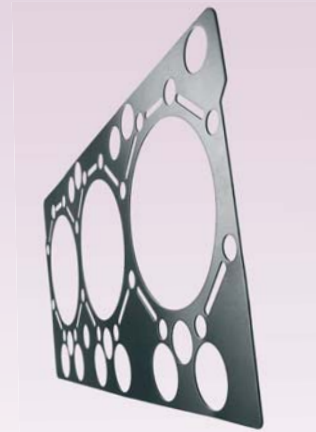
-  Respiratory protection suggested
-  Eye protection suggested
-  Ear protection suggested
-  Protective clothing suggested
-  Extra level of eye protection suggested



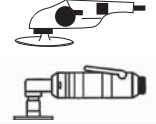

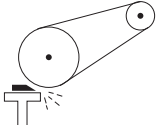
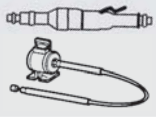
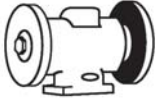
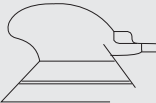




# Deburring

Solutions for all deburring applications from light burrs on precision parts where tolerances are critical, to coarse chamfering of rough edges.



Page No.	Abrasive System	Products
22	 Depressed centre disc angle grinder	3M™ Flap Discs 574F Scotch-Brite™ Unitised Discs
23	 Fibre disc angle grinder	3M Fibre Discs 501C Scotch-Brite Surface Conditioning Discs SC-DB Accessories
24	 Mini grinder system / Right angled die grinder	3M Roloc™ Discs 785C/777F EXL Unitised Roloc Discs Accessories
25	 File belt tool	3M Cubitron™ Cloth Belts 947D 3M Cubitron Cloth Belts 777F Scotch-Brite Surface Conditioning Belts SC-BS
26	 Backstand / Linisher	3M Cloth Belts 577F Orange 3M Cloth Belts 251D
27	 Straight grinder, straight die grinder & portable flexible shaft machine	3M Flap Wheels 449 Scotch-Brite Unitised Wheels Scotch-Brite Radial Bristle Abrasives Accessories
28	 Spindle machine (bench / floor)	Scotch-Brite Deburring Wheels Scotch-Brite EXL Unitised Wheels Scotch-Brite Bristle Abrasives Accessories
29	 Orbital sander	3M Hookit™ Discs 245 3M Hookit™ Discs 255P Accessories

## Depressed centre disc angle grinder

- Portable and versatile tool ideal for fabrication shops
- No back-up pads required: abrasive discs are secured directly onto the tool
- Ideal for sheet edge deburring / chamfering



### Top tip

Use Scotch-Brite™ Unitised Discs to achieve a smooth radiused edge when removing small burrs.



### 3M™ Flap Disc 574F



- High performance Alumina Zirconia fibre disc
- High cut rate for heavy duty deburring applications



3M 574F Conical	P40	P60	P80
100mm x 16mm	61562	61563	61564
115mm x 22mm	61565	61566	61567
127mm x 22mm	61568	61569	61570
180mm x 22mm	61574	61575	61576

### Scotch-Brite™ Unitised Disc



- Deburrs without undercutting to leave a true, radiused edge
- Consistent performance throughout product life to deliver repeatable results
- Durable product construction means fewer disc changes and less downtime



CP-UD	7AMED
115mm x 22mm	29205

**3M Best Performer ✓**



XL-UD	2SFIN
115mm x 22mm	29201

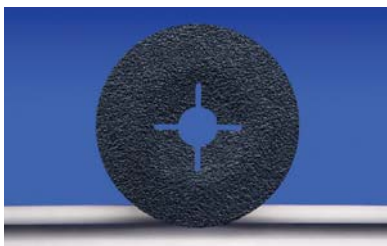


## Fibre disc angle grinder

- Portable and versatile tool ideal for fabrication shops
- Back-up pad required to support the disc
- Ideal for sheet edge deburring and chamfering where greater flexibility when compared to a rigid disc system is required



### 3M™ Fibre Disc 501C



- High performance Alumina Zirconia fibre disc
- Excellent mineral retention for edge grinding
- High cut rate for heavy duty deburring applications



3M 501C	P60	P80	P120
100mm x 16mm	A60499	A60500	N/A
115mm x 22mm	A60506	A60507	A60509
125mm x 22mm	A60513	A60514	A60516
180mm x 22mm	A60520	A60521	A60523

### Scotch-Brite™ Surface Conditioning Disc (fibre-backed)



- Deburrs with reduced risk of undercutting compared to a fibre disc
- Consistent performance throughout disc life to deliver repeatable results



SC-DB	Super Duty
100mm x 16mm	61948
115mm x 22mm	61947
178mm x 22mm	61945

### Back-Up Pad



- Flat, semi-flexible design to maximise edge contact whilst deburring
- Durable construction means long product life

Back-Up Pad	Flat Semi-Flex
100mm x M10 - 1.5	07312
115mm x M14 - 2.0	07306
125mm x M14 - 2.0	09386
178mm x M14 & 5/8 Whit	09387

## Mini grinder system & right-angled die grinder

- Versatile system for all applications, particularly detail work
- Use of 3M™ Roloc™ Back-Up Pad provides positive fixing with rapid grade or product change, allowing you to tackle any deburring job
- 3M™ Roloc system allows greater access to workpiece compared to conventional disc attachments

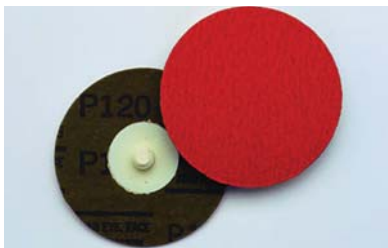


### Top tip

Use the colour-coded Roloc Quick Release System to select the 3M product most suited to your application.



### 3M Roloc Abrasive Discs 785C/777F



- Contain 3M Cubitron™ Mineral for maximum efficiency in heavy duty deburring applications
- Fibre backed 3M 785C discs offer greater durability on electric angle grinders
- Cloth-backed 3M 777F discs are suited to lighter deburring applications, particularly when paired with air die grinders



3M 785C	P60 Orange	P80 Yellow	P120 White
75mm dia	85885	85886	85888



3M 777F	P60 Orange	P80 Yellow	P120 White
75mm dia	76633	76634	249846
50mm dia	76433	14661	170935

### 3M Roloc EXL Unitised Disc



- This product can be used on its face, or on its edge as a wheel
- Suitable for all deburring jobs
- Deburrs without undercutting to leave a true, radiused edge



XL-DR	6AMED
75mm dia	17191
50mm dia	17190

3M Best Performer ✓



XL-DR	2SFIN
75mm dia	17184
50mm dia	17183

3M Best Performer ✓

### 3M Roloc Back-Up Pads



- Rubber back-up pads offer greater flexibility, and are available with 6mm shaft and female thread options to fit angle grinders
- Plastic back-up pads are for use where flexibility is not required, available with 6mm shaft only

Roloc Rubber Back-Up Pad	Hard density
75mm x M14 - 2.0	84998
75mm x M10 - 1.5	85000
75mm x 1/4" thread*	45091
50mm x 1/4" thread*	A45096
6mm shaft, (*use with)	82455

Roloc Plastic Back-Up Pad	Plastic
No.4, 75mm dia, 6mm shaft	09988
No.3, 50mm dia, 6mm shaft	09987
No.1 25mm dia, 6mm shaft	09884

## File belt tool

- Lightweight, handheld tool with ergonomic off-set design
- Quick belt change feature
- Increases operator capability to access hard-to-reach areas via a comprehensive range of contact arms



### 3M Cubitron™ Belt 777F



- Contains Cubitron Mineral for maximum efficiency in heavy duty deburring applications
- Stiffer, Y-weight backing for optimum performance on sharper, tougher burrs



3M 777F	P60	P80	P120
13mm x 305mm	65111	65112	221303
13mm x 457mm	65143	65144	221305
20mm x 457mm	65151	65152	221320X
13mm x 533mm	65191	65192	365440
13mm x 610mm	65215	65216	221307

### 3M Cubitron™ Belt 947D



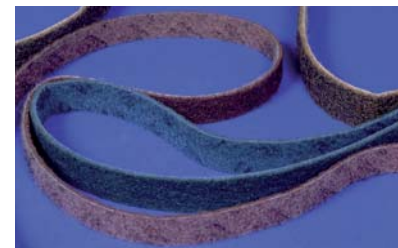
- Contains Cubitron Mineral for maximum efficiency in medium duty deburring applications
- Tough X-weight cloth backing offers good conformability and strength



3M 947D	P60	P80	P120
13mm x 305mm	438484	438483	-
13mm x 457mm	111511	418218	450626
20mm x 457mm	101604	365547	450627
13mm x 533mm	431438	423522	463482
13mm x 610mm	434002	393931	459482

3M Best Performer ✓

### Scotch-Brite™ Surface Conditioning Belt



- A tough, non-woven nylon web impregnated with mineral throughout its structure to deliver high quality, repeatable results and consistent performance throughout product life
- Deburr without undercutting to leave a radiused edge
- Suited to lighter deburring applications



SC-BS	CRS	MED	VFN
13mm x 305mm	65344	65345	65346
13mm x 457mm	66141	65232	66142
20mm x 457mm	66143	65234	66144
13mm x 533mm	05325	65244	335591
13mm x 610mm	05655	65250	05654

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.



## Backstand/Linisher machine

- For deburring most small parts
- Ideal for higher volume and complex parts where greater control is needed - part to belt
- Offers versatility through the use of different belt widths and the ability to change from contact wheel to platen or slack of belt to access all areas of the part

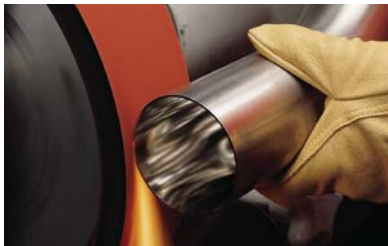


### Top tip

To achieve a smoother, more radiused deburred edge, use a machine with slack of belt option. Working off the contact wheel will produce a more chamfered edge.



### 3M™ Cloth Belt 577F Orange



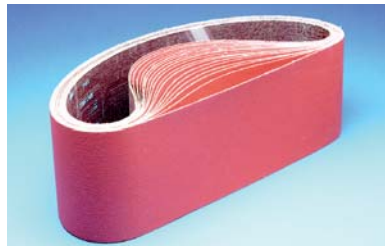
- Alumina Zirconia mineral for optimum performance in heavy duty deburring applications on this type of machinery
- Stiffer Y-weight backing for sharper, tougher burrs



3M 577F Orange	P60	P80	P120
100mm x 915mm	456023	-	-
50mm x 1525mm	447297	461764	-
75mm x 2000mm	448724	450711	-
150mm x 2000mm	454634	448356	388634
100mm x 2500mm	449594	-	-

3M Best Performer ✓

### 3M Cloth Belt 251D

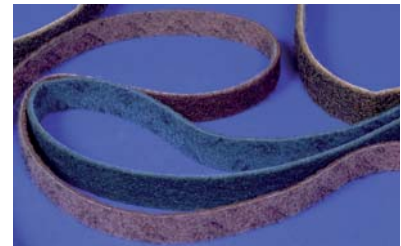


- General purpose Aluminium Oxide belt for lighter duty applications
- Tough X-weight cloth backing gives good conformability and strength



3M 251D	P180	P240
100mm x 915mm	436201	435729
50mm x 1525mm	445934	439360
75mm x 2000mm	-	443068
150mm x 2000mm	-	-
100mm x 2500mm	-	-

### Scotch-Brite™ Surface Conditioning Belt



- A tough, non-woven nylon web impregnated with mineral throughout its structure which delivers repeatable results
- Deburs without undercutting, leaving a radiused edge
- Suited to lighter deburring applications, this product offers consistent performance throughout its life



SC-BL	SE-ACRS	CRS	MED
100mm x 915mm	-	240477	243255
50mm x 1525mm	430536	238418	250371
75mm x 2000mm	462411	221744	221745
150mm x 2000mm	-	189238	190505
100mm x 2500mm	457411	438035	437961

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

## Straight grinder, straight die grinder & portable flexible shaft machine

- Use for larger workpieces where the tool is brought to the job
- A die grinder is the best option for small or confined areas
- Straight grinders normally have a shaft to directly mount products, whereas die grinders and flexible shaft machines use a collet for shaft mounted conversions



### 3M™ Flap Wheel 449



- Aluminium Oxide abrasive flap wheel with 6mm shaft
- Conformable construction for deburring on contoured parts
- Available in a variety of grades to match the severity of the application



3M 449	P60	P80	P120
30mm x 15mm x 6mm	65397	65402	65407X
40mm x 20mm x 6mm	65398	65403	N/A
60mm x 30mm x 6mm	65400	65405	65410

### Scotch-Brite™ Unitised Wheel



- Deburr without undercutting, leaving a true radiused edge
- Consistent performance throughout wheel life, delivering repeatable results
- Durable product construction means fewer wheel changes resulting in less down time



XL-UW	6AMED	2AMED
38mm x 3mm x 4.8mm	15515	N/A
51mm x 6mm x 6.35mm	03786	03781
76mm x 6mm x 6.35mm	-	15531
152mm x 12mm x 12.7mm	-	-



XL-UW	2SFN
51mm x 6mm x 6.35mm	09831
76mm x 6mm x 6.35mm	13716
152mm x 12mm x 12.7mm	13719

**3M Best Performer ✓**

Accessories	992M	933M	900-6
4.8mm centre hole wheels	85076	N/A	N/A
6.35mm centre hole wheels	N/A	00933	N/A
12.7mm centre hole wheels	N/A	N/A	A07947

### Scotch-Brite Radial Bristle Brush



- A brush consists of a series of discs, each made from a one piece moulded construction and impregnated with 3M Cubitron™ Mineral to give a consistent finish and performance throughout product life
- When compared to wire brushes, the Radial Bristle construction eliminates hazards from flying wires; minimal pressure is required making the product extremely easy and comfortable to use
- Suitable for light deburring applications where conformability is required



Radial Bristle Discs	Type A P50 Green	Type C P80 Yellow	Type C P120 White
19mm dia	N/A	25755	-
50mm dia	N/A	30118	30120
75mm dia	24279	30126	30127
150mm dia	A27605	33215	33212

Accessories	990M	900-6
50mm x 75mm dia	325310	N/A
150mm dia	N/A	A07947

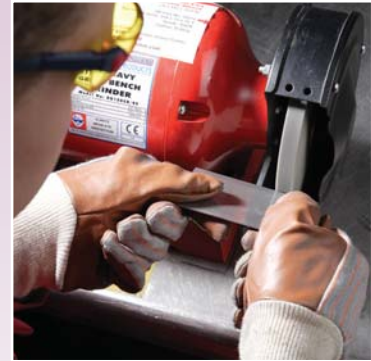
Type A bristles are thicker and angled for heavy duty applications.

Type C bristles are thinner and curved for greater conformability.

Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

## Spindle machine (bench or floor mounted)

- For deburring most small fabricated parts
- Ideal for higher volume and complex parts where greater control is required - part to abrasive
- Facility to mount a large range of different rotary abrasives to achieve desired results – e.g. wheels and brushes



### Top tip

Convolute (deburring) wheels have a central core, making them the first choice for use with flanges on straight shafts. Unitted wheels have a cut-out centre hole and can be used on tapered spindles.



### Scotch-Brite™ Deburring Wheel



- Convolute wound construction provides long life, consistent results and a controlled action, leading to improved product quality and a reduction in rejects
- Produces a true radiused edge without affecting the dimensions of the part, meaning less re-work with a better quality finish first time
- Range of hardnesses available to tackle most burr sizes - the X3-WL is the most durable for the toughest burrs



Scotch-Brite Deburring Wheels	X3-WL 9SFN	DB-WL 9SFN	DB-WL 7SFN
152mm x 12mm x 25.4mm	30214	-	-
152mmx25.4mm x 25.4mm	30213	18762	18768
203mmx25.4mm x 76.2mm	24579	18764	18769

**3M Best Performer ✓**

Accessories	Flanges	Spindle Adaptor
25.4mm x 12.7mm	61327	N/A
76.2mm x 12.7mm	A61311	N/A
76.2mm x 50mm width	N/A	09662

### Scotch-Brite Unitted Wheel



- Deburr without undercutting, leaving a true radiused edge
- Consistent performance throughout wheel life delivering repeatable results
- Durable product construction means fewer wheel changes, resulting in less down time

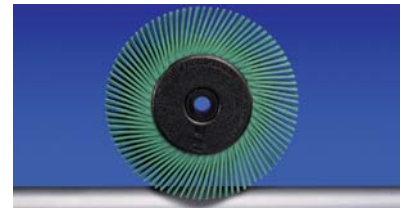


XL-UW	6AMED	2AMED
152mm x 12mm x 12.7mm	-	-
203mm x 25mm x 12.7mm	-	-



XL-UW	2SFN
152mmx x12mm x 12.7mm	13719
152mm x 25mm x 12.7mm	13742
203mm x 25mm x 12.7mm	30382

### Scotch-Brite Radial Bristle Brush



- A brush consists of a series of discs, each made from a one piece moulded construction impregnated with Cubitron Mineral to give a consistent finish and performance throughout product life
- When compared to wire brushes, the bristle construction eliminates hazardous flying wires; minimal pressure is required from the operator, making the product extremely easy and comfortable to use
- Suitable for light deburring applications where conformability is required



Radial Bristle Disc	Type A P50 Green	Type S P50 Green	Type C P80 Yellow	Type C P120 White
150mm x 13mm	27605	N/A	33215	33212
203mm x 25mm	N/A	33081	33129	33130

Type A bristles are thicker and angled for heavier duty applications.

Type C bristles are thinner and curved for greater conformability.

Type S bristles are straight for increased aggression.

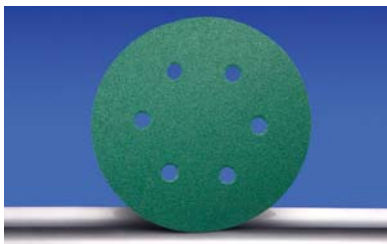
Where no part number is shown, please call the Customer Services Team for availability on 0161 237 6390.

## Orbital sander

- Orbital motion produces a random scratch pattern
- Ideal for large accessible areas
- Use for deburring punched holes on flat parts



### 3M Hookit™ Disc 245



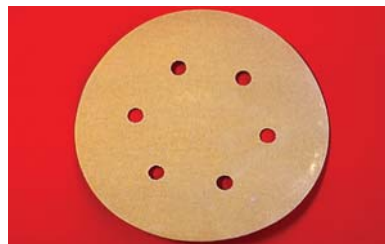
- 3M Hookit fixing system allows the product to be attached and reattached as many times as necessary
- 3M 245 is the ideal choice for more demanding deburring applications due to its heavy duty E-weight paper backing
- Open coat construction helps prevent premature loading and extends product life, especially on aluminium



3M Hookit 245	P60	P80	P120
150mm x Plain	A01648	A01647	A01645
150mm x 6 hole	A01690	A01689	A01687

3M Best Performer ✓

### 3M Hookit™ Disc 255P



- 3M Hookit fixing system allows the product to be attached and reattached as many times as necessary
- High performance C-weight paper 255P disc is suited to lighter duty deburring applications
- Incorporates Fre-Cut Anti-Loading Coating to prevent clogging and extend product life, especially on aluminium



3M Hookit 255P	P80	P120	P180
150mm x Plain	A00341	A00339	A00337
150mm x 6 hole	A00329	A00327	A00325

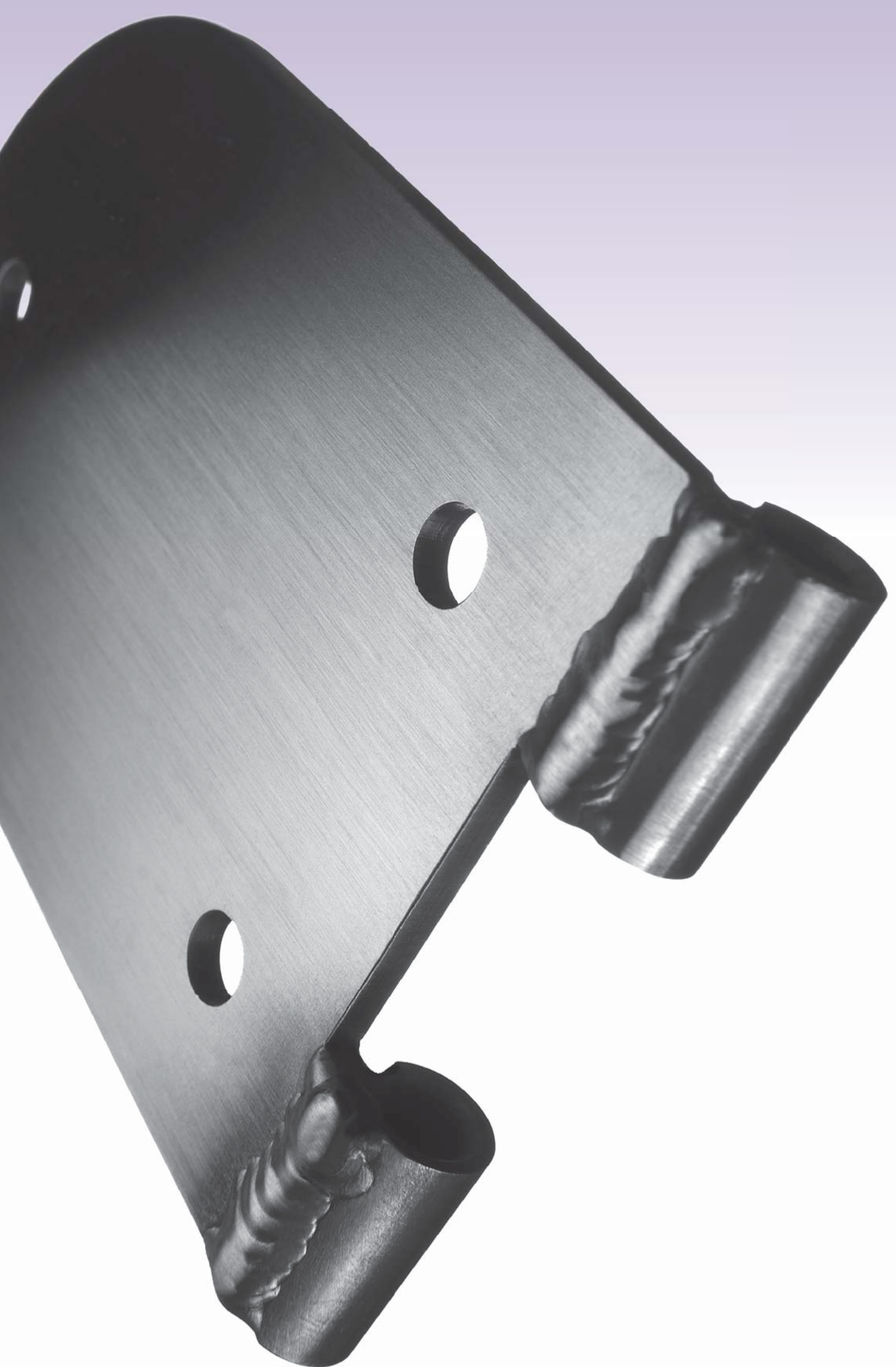
### 3M Hookit Back-Up Pad



- Rated to 12,000 rpm for use on the latest higher speed random orbital sanders
- Durable polyurethane construction for maximum life and good flexibility
- Well balanced for smooth running and reduced vibration

3M Hookit Back-Up Pads	
150mm x Plain	07389
150mm x 6 hole	05876









**Abrasive Systems  
Customer Service Group**

3M House, 28 Great Jackson Street  
Manchester M15 4PA  
United Kingdom  
Phone: 0161 237 6390  
Fax: 0161 237 1106  
Email: [abrasives.uk@mmm.com](mailto:abrasives.uk@mmm.com)  
[www.3m.com/uk/abrasives](http://www.3m.com/uk/abrasives)

3M House, Adelphi Centre  
Upper Georges St, Dun Laoghaire  
Co. Dublin, Ireland  
Tel: 01 2803555  
Fax: 01 2803509

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