

Scotch-Brite™

Surface Conditioning Wheels

*Convolute and unitized –
the most complete selection in the industry*



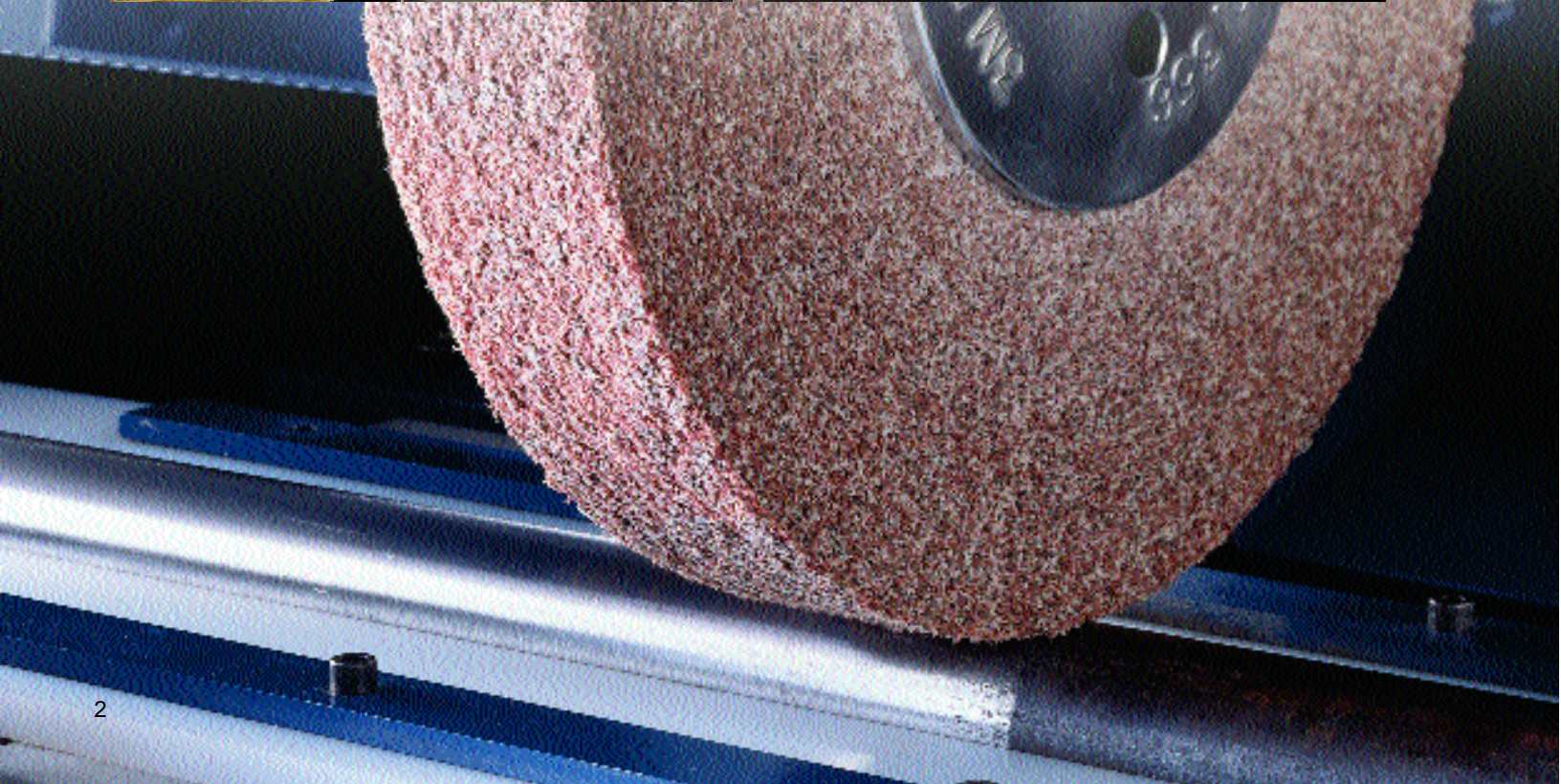
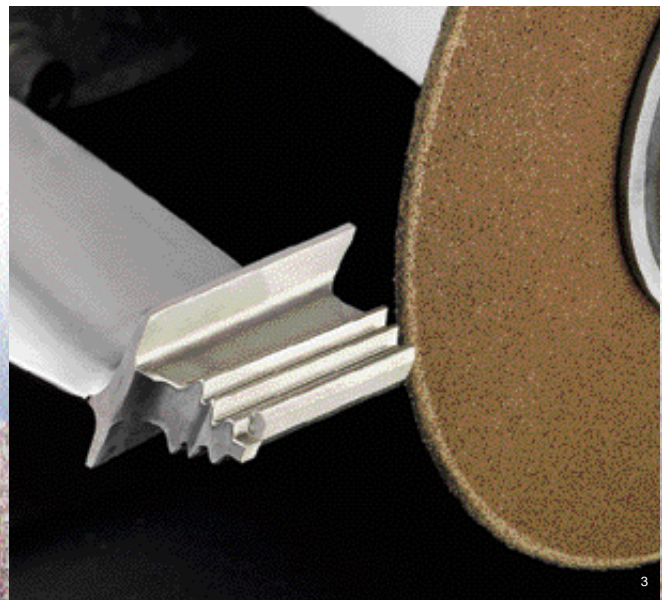
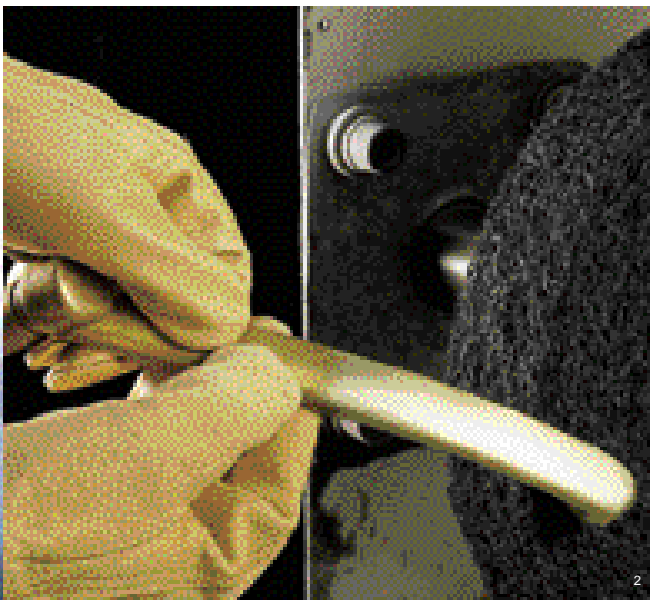
Scotch-Brite™ Wheels

The industry standard and most complete selection of surface conditioning wheels provide customers with the highest level of performance and value. 3M continues to set the pace in developing non-woven wheels, as it has for more than four decades, with new and advanced technology while continuously improving its existing product line.

In addition, customers are supported by 3M Innovation Centers around the world, staffed by Technical Service teams dedicated to increasing customers' productivity, reducing manufacturing costs and helping them stay ahead of their competition.

Scotch-Brite wheels:

- Improve surfaces without significantly changing the shape or dimension of the workpiece
- Are well-suited for cleaning, blending, deburring, finishing and polishing
- Help prevent undercutting or gouging through their controlled abrasive action
- Provide consistent, uniform finishes as fresh abrasives are continually exposed to the work surface
- Run cool and resist loading due to their open web construction, reducing the risk of part discoloration and warping while extending the life of the wheel



Factors to consider when choosing a starting point for your application:

- Composition of workpiece and material type
- Material hardness
- Desired results to be achieved
- Size and shape of the work piece–area to be conditioned
- Part variability
- Tool/machinery type, including speed capability
- Previous and possible subsequent abrasive steps

Scotch-Brite™ wheels can show value when replacing:

- Steel wool
- Conventional coated abrasives
- Hand files
- Carbide burrs
- Hand knives and scrapers
- Sand blasting
- Wire brushes
- Tampico and bristle brushes
- Buffs and compounds
- Rubber bonded wheels
- Set-up wheels

Selecting convolute vs. unitized

This choice will often be dictated by the part configuration, wheel size availability, tool speed, or other fixed circumstances.

Convolute is a wrapped construction on a standard sized core. The "flat" of the web becomes the cutting tool. The wheels are one directional– indicated by an arrow on the side of the wheel and arrows printed in the core.

Unitized is a layered construction with a selection of center hole sizes and no core. The "edge" of the web becomes the cutting tool. The wheels are non-directional.

Basic performance differences:

Grade for grade– Convolute will tend to produce a finer finish; unitized will be more aggressive and durable.

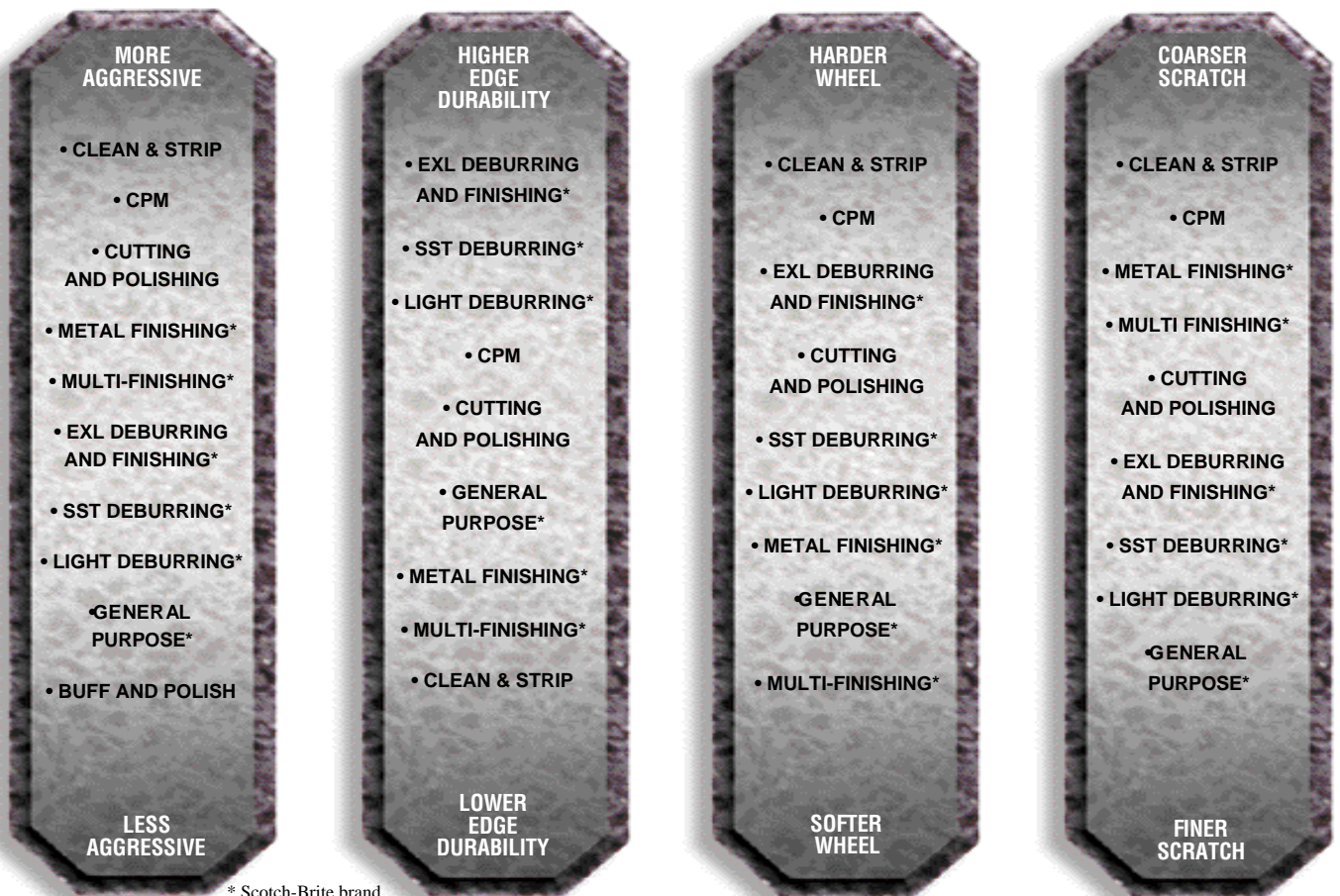
Density– The number may be the same (i.e. 6 density) but the unitized wheel will always act harder and be less conformable.

Wheel size availability is often a factor when making this selection.

Convolute wheel selection is 4"-24" diameter, 1/2"-36" wide. Exceptions depend on product type. Refer to the specific description page for availability.

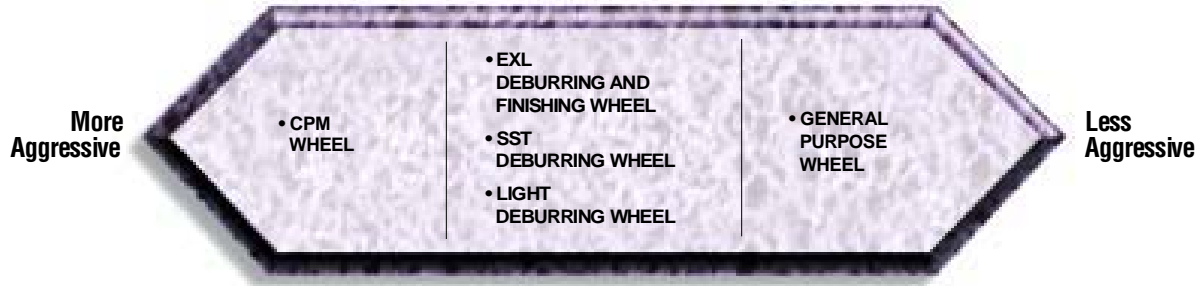
Unitized wheel size selection is 1/2"-14" diameter and from 1/8"-1" wide. Exceptions depend on product type. Refer to the specific description page for availability.

Performance ranking of wheels by general category



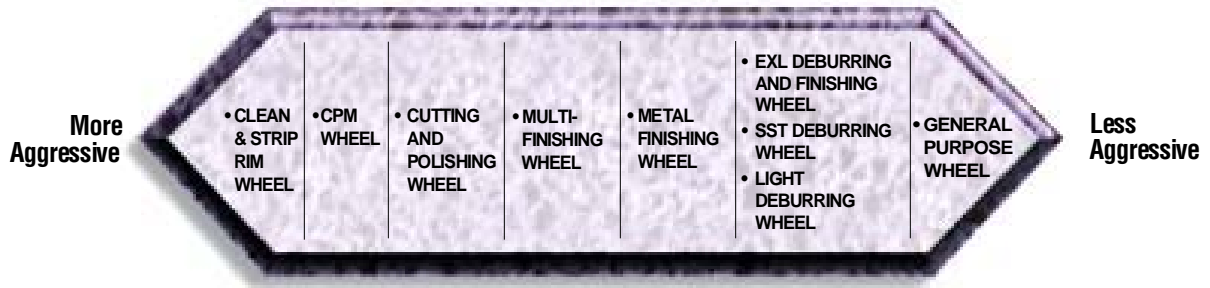
* Scotch-Brite brand

Scotch-Brite™ Wheels for Deburring



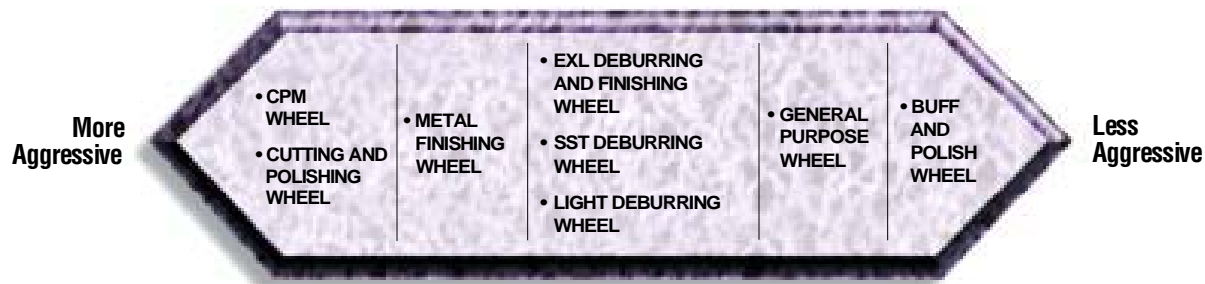
Applications	Starting Point	Alternatives: More Aggressive	Less Aggressive
Carbon Steels:			
Hole deburring on machined or formed parts	SST Deburring Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Deburr shear edges	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EX2 Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 9S-fine (FIN)
Deburr keyways	EXL Deburring and Finishing Wheel, 9S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Stainless Steel, Titanium (Nickel Alloys):			
Deburr leading and trailing edges of jet engine turbine blades	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Level Cut Wheel, 5A-fine (FIN)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Remove wire edges from surgical instruments	EXL Deburring and Finishing Wheel, 9S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Radius edges of stamped metal parts	EXL Deburring and Finishing Wheel, 9S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Deburr stainless steel piston rings	SST Deburring Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)	Light Deburring Wheel, 7A-fine (FIN)
Aluminum, Copper, Brass (Soft Metals)			
Deburr aluminum die cast flashing	SST Deburring Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Break edges of aluminum extrusions	EXL Deburring and Finishing Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 9S-fine (FIN)	Light Deburring Wheel, 8S-fine (FIN)
Deburr automotive or appliance trim	SST Deburring Wheel, 7A-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Light Deburring Wheel, 8S-fine (FIN)
Deburr edges of brass medallions	Light Deburring Wheel, 6S-fine (FIN)	Light Deburring Wheel, 7S-fine (FIN)	General Purpose Wheel, 5A-very fine (VFN)
Other – Composites, Plastics, Glass, etc.:			
Deflash edges of molded plastic parts	General Purpose Wheel, 6S-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)	General Purpose Wheel, 5A-very fine (VFN)

Scotch-Brite™ Wheels for Cleaning



Applications	Starting Point	Alternatives: More Aggressive	Less Aggressive
Carbon Steels:			
Remove zinc buildup after plating	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-medium (MED)	Cutting and Polishing Wheel, 7A-coarse (CRS)
Clean surface of steel plate prior to welding	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-coarse (CRS)	CPM Wheel, 5A-fine (FIN)
Remove scale and oxide from steel rounds	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-medium (MED)	Cutting and Polishing Wheel, 7A-coarse (CRS)
Strip coating from steel surfaces	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-coarse (CRS)	CPM Wheel, 5A-fine (FIN)
Stainless Steel, Titanium (Nickel Alloys):			
Clean surface prior to welding	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-coarse (CRS)	EXL Deburring and Finishing Wheel, 8A-medium (MED)
Remove weld discoloration	Cutting and Polishing Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	Metal Finishing Wheel, 6A-Medium(MED)
Strip gasket from stainless steel valves	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	CPM Wheel, 7A-coarse (CRS)	Cutting and Polishing Wheel 7A-medium (MED)
Clean surface prior to bonding	Cutting and Polishing Wheel, 7A-medium (MED)	Clean & Strip Rim Wheel, 7S-extra coarse (XCS)	Cutting and Polishing Wheel, 5A-fine (FIN)
Aluminum, Copper, Brass (Soft Metals)			
Condition surface prior to welding	Light Deburring Wheel, 6S-fine (FIN)	SST Deburring Wheel, 7A-fine (FIN)	General Purpose Wheel, 6S-fine (FIN)
Remove light oxide	General Purpose Wheel, 5A-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)	General Purpose Wheel, 5A-very fine (VFN)
Clean copper electrical buss bars	Cutting and Polishing Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	SST Deburring Wheel, 8S-fine (FIN)
Other – Composites, Plastics, Glass, etc.:			
Remove excess resin squeeze out from composite parts	Multi-Finishing Wheel, 2S-medium (MED)	Multi-Finishing Wheel, 2S-coarse (CRS)	Multi-Finishing Wheel, 2S-fine (FIN)

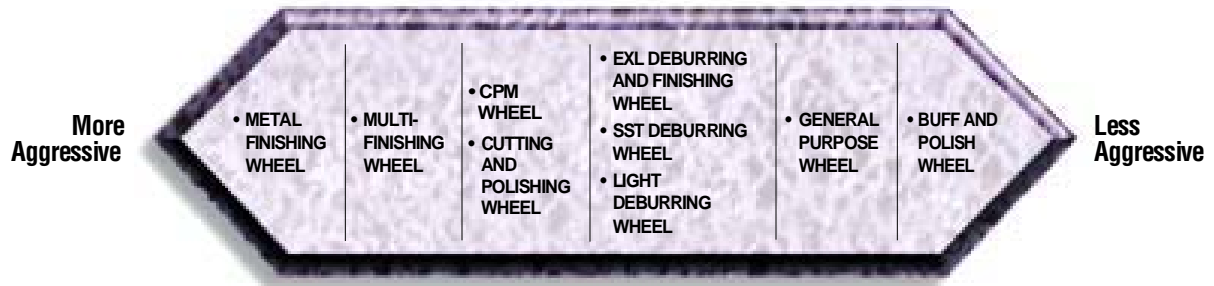
Scotch-Brite™ Wheels for Polishing



Applications	Starting Point	Alternatives: More Aggressive	Less Aggressive
Carbon Steels:			
Centerless polish hydraulic rods to lower Ra	Cutting and Polishing Wheel, 7A-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	SST Deburring Wheel, 7S-fine (FIN)
O.D. polish roller bearings	SST Deburring Wheel, 8S-fine (FIN)	Cutting and Polishing Wheel, 7A-fine (FIN)	General Purpose Wheel, 6A-fine (FIN)
Polish hydraulic valve spools	Light Deburring Wheel, 8S-fine (FIN)	SST Deburring Wheel, 8S-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)
Mold and die polishing	Light Deburring Wheel, 6S-fine (FIN)	SST Deburring Wheel, 7S-fine (FIN)	General Purpose Wheel, 6S-super fine (SFN)
Stainless Steel, Titanium (Nickel Alloys):			
Final polish surgical instruments	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Cutting and Polishing Wheel, 7A-medium (MED)	SST Deburring Wheel, 8S-fine (FIN)
Final polish prosthetic devices	SST Deburring Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Light Deburring Wheel, 6S-fine (FIN)
Polish aircraft component parts	Light Deburring Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)
Aluminum, Copper, Brass (Soft Metals)			
Polish prior to plating	General Purpose Wheel, 6S-very fine (VFN)	Light Deburring Wheel, 6S-fine (FIN)	General Purpose Wheel, 6S-super fine (SFN)
Selective polish brass medallions	General Purpose Wheel, 6S-ultra fine (ULF)	General Purpose Wheel, 6S-super fine (SFN)	Buff and Polish Wheel,* medium density
Selective polish name plates	Light Deburring Wheel, 8S-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	General Purpose Wheel, 6S-super fine (SFN)
Jewelry polishing plates	General Purpose Wheel, 5S-super fine (SFN)	Light Deburring Wheel, 6S-fine (FIN)	Buff and Polish Wheel,* soft density
Other – Composites, Plastics, Glass, etc.:			
Polish bevel edge of furniture glass	General Purpose Wheel, 6A-very fine (VFN)	Light Deburring Wheel, 8S-fine (FIN)	General Purpose Wheel, 6S-super fine (SFN)
Fiber optic end polishing	Buff and Polish Wheel,* medium density	Buff and Polish Wheel,* hard density	Buff and Polish Wheel,* soft density

* Buff and Polish Wheels are non-abrasive and designed to work with compounds.

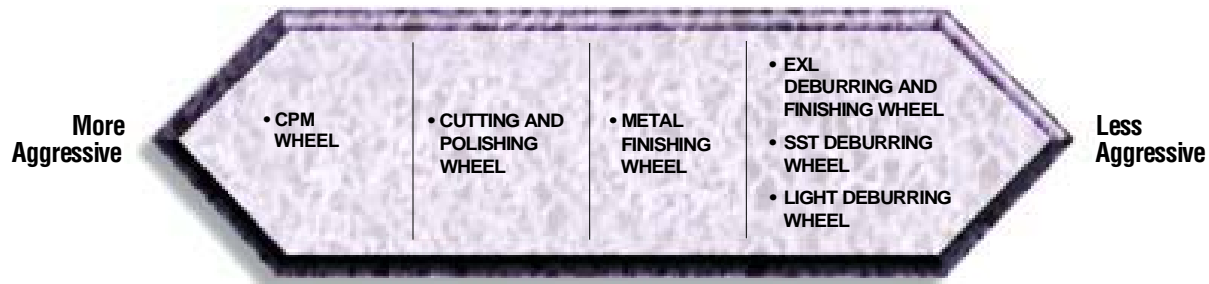
Scotch-Brite™ Wheels for Finishing



Applications	Starting Point	Alternatives: More Aggressive	Less Aggressive
Carbon Steels:			
Finish surface of hand tools to low Ra prior to plating	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Cutting and Polishing Wheel, 7A-medium (MED)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Decorative satin finishing	Metal Finishing Wheel, 5A-medium (MED)	Metal Finishing Wheel, 6A-coarse (CRS)	Multi-finishing Wheel, 2S-fine (FIN)
Gun barrel finishing after machining	Cutting and Polishing Wheel, 7A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	Cutting and Polishing Wheel, 7A-very fine (VFN)
Finish prior to buffing or plating	SST Deburring Wheel, 8S-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	Light Deburring Wheel, 8S-fine (FIN)
Stainless Steel, Titanium (Nickel Alloys):			
Provide #3 mill finish	Multi-finishing Wheel, 2S-coarse (CRS)	Metal Finishing Wheel, 5A-coarse (CRS)	Metal Finishing Wheel, 6A-medium (MED)
Provide #4 mill finish	Multi-finishing Wheel, 2S-medium (MED)	Metal Finishing Wheel, 5A-medium (MED)	Multi-finishing Wheel, 2S-fine (FIN)
Satin finish cutlery	Metal Finishing Wheel, 5A-medium (MED)	Metal Finishing Wheel, 5A-coarse (CRS)	Multi-finishing Wheel, 2S-fine (FIN)
Finish prior to buffing	Light Deburring Wheel, 6S-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	General Purpose Wheel, 5A-very fine (VFN)
Aluminum, Copper, Brass (Soft Metals)			
Decorative finish builders hardware	General Purpose Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)
Final finish aluminum extrusions	Multi-finishing Wheel, 2S-coarse (CRS)	Metal Finishing Wheel, 4A-medium (MED)	Multi-finishing Wheel, 2S-medium (MED)
Finish prior to buffing or plating	General Purpose Wheel, 6S-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)	General Purpose Wheel, 5A-very fine (VFN)
Other – Composites, Plastics, Glass, etc.:			
Satin finish plastic automotive trim after plating	Multi-Finishing Wheel, 2S-fine (FIN)	Metal Finishing Wheel, 5A-medium (MED)	Light Deburring Wheel, 6S-fine (FIN)



Scotch-Brite™ Wheels for Blending



Applications	Starting Point	Alternatives: More Aggressive	Less Aggressive
Carbon Steels:			
Blend 80 grit coated abrasive belt grind lines	CPM, 5A-medium (MED)	CPM, 5A-coarse (CRS)	CPM, 5A-fine (FIN)
Blend brazing of steel tubing prior to plating	Cutting and Polishing Wheel, 5A-fine (FIN)	CPM, 5A-medium (MED)	Metal Finishing Wheel, 6A-fine (FIN)
Conditioned machined surface of compressor shafts	Cutting and Polishing Wheel, 7A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	SST Deburring Wheel, 7A-fine (FIN)
Blend 80 grit coated abrasive disc grind lines	CPM, 5A-coarse (CRS)	CPM, 9A-coarse (CRS)	CPM, 5A-medium (MED)
Stainless Steel, Titanium (Nickel Alloys):			
Refine surface of jet blade airfoils	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Cutting and Polishing Wheel, 5A-fine (FIN)	EXL Deburring and Finishing Wheel, 8S-fine (FIN)
Remove parting lines from cast turbine blades and vanes	EXL Deburring and Finishing Wheel, 8S-fine (FIN)	EXL Deburring and Finishing Wheel, 8A-medium (MED)	Light Deburring Wheel, 7S-fine (FIN)
Blend surface of surgical instruments	SST Deburring Wheel, 8S-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	Light Deburring Wheel, 8S-fine (FIN)
Blend 100 grit coated abrasive grind lines	Cutting and Polishing Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	Metal Finishing Wheel, 6A-medium (MED)
Aluminum, Copper, Brass (Soft Metals)			
Blend 120 grit coated grind lines	Cutting and Polishing Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 7A-fine (FIN)	Multi-Finishing Wheel, 2S-fine (FIN)
Remove light imperfections from part surface	Metal Finishing Wheel, 5A-medium (MED)	Cutting and Polishing Wheel, 5A-fine (FIN)	Multi-Finishing Wheel, 2S-fine (FIN)
Condition cast surface prior to plating or buffing	Multi-Finishing Wheel, 2S-fine (FIN)	Cutting and Polishing Wheel, 5A-fine (FIN)	Light Deburring Wheel, 6S-fine (FIN)
Other – Composites, Plastics, Glass, etc.:			
Remove mold flash from rubber/plastic parts	Cutting and Polishing Wheel, 5A-fine (FIN)	Cutting and Polishing Wheel, 7A-medium (MED)	General Purpose Wheel, 6A-medium (MED)

Scotch-Brite™ EXL, EX2, EX3 Deburring and Finishing Wheels



Designed for top performance and value on a variety of critical deburring and finishing applications.

The EXL family of convolute wheel products is especially well suited for a broad range of deburring and finishing needs. The unique resin system helps to minimize smearing and the wheels show superior performance on stainless steel, titanium and high nickel alloys.

The 8 density in EXL, EX2 or EX3 wheels should be selected for operations requiring a combination of deburring and finishing.

The 9 density in EXL, EX2, or EX3 wheels performs best in more severe deburring applications where the wheel is consistently presented with a sharp edge.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade	
EXL	8, 9	Silicon Carbide	FIN	Hard
	8	Silicon Carbide	MED	
	8	Aluminum Oxide	MED	
EX2	8, 9	Silicon Carbide	FIN	Harder
	8	Silicon Carbide	MED	
	8	Aluminum Oxide	MED	
EX3	8, 9	Silicon Carbide	FIN	Hardest
	8	Silicon Carbide	MED	
	8	Aluminum Oxide	MED	

Diameters: 4" minimum 24" maximum

Widths: 3/8"-36" in 4, 6, 8" diameters
1/2"-36" in 10, 12" diameters
3/4"-36" in 14"-24" diameters

Typical applications:

- Cutlery—deburring and edge radius
- Jet blades—blending, finishing, deburring
- Gun barrels—polishing
- Golf club heads—polishing, finishing
- General use deburring

Some additional sizes may be available by special request
See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ EXL Unitized Wheels



An excellent choice for deburring and polishing of all metal alloys as well as many plastics and composites.

Like EXL convolute wheels they resist smearing and minimize heat buildup on the workpiece.

There is a wide variety of densities and grades available from a very soft 2 density for applications requiring a conformable product all the way to a hard, aggressive 8 density for maximum cut and durability.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
EXL Unitized	2	Silicon Carbide	VFN
	2, 3, 4, 6	Silicon Carbide	FIN
	4, 6	Aluminum Oxide	FIN
	2, 6, 8	Aluminum Oxide	MED
	8	Aluminum Oxide	CRS
	2, 4, 6, 8	Aluminum Oxide	XCS

Diameters: 1/2" minimum 14" maximum

Widths: 3, 6, 8 density 2, 4 density in
in 1/8" minimum 1/4" minimum
1" maximum all diameters

Typical applications:

- Weld cleaning
- Finishing threaded parts
- Turbine blade polishing
- Metal stampings

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Roloc™ EXL Unitized Wheels



EXL Roloc™ Unitized wheels are strong and efficient for edge deburring and finishing. They perform well in a variety of metal working applications and machined parts where close tolerances are important.

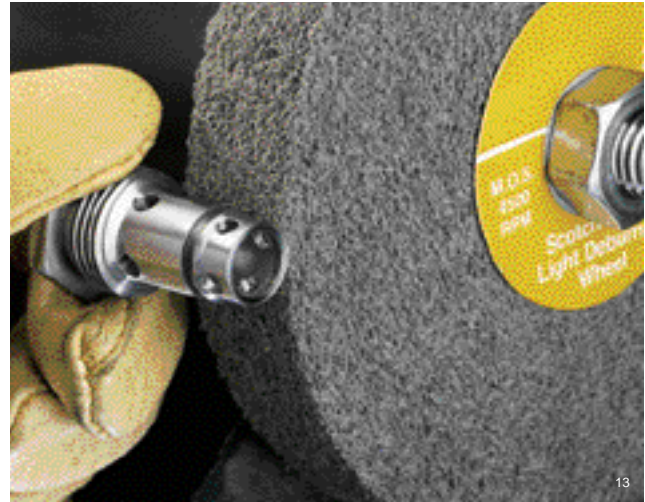
Changing wheels is quick and easy with Roloc TR, Roloc TS, or Roloc + holding systems. Allow for use of both the edge and surface of the wheel without interruption of mountain hardware. Mounting system is interchangeable with Scotch-Brite™ Surface Conditioning Discs and Coated Abrasive Discs.

Product Name	Density	Mineral Type	Grade
EXL Roloc Unitized	2, 3, 6	Silicon Carbide	FIN
	2, 6, 8	Aluminum Oxide	MED
	8	Aluminum Oxide	CRS
	2, 4, 6, 8	Aluminum Oxide	XCS

Diameters: 2" and 3"
Widths: NA

- Typical applications:**
- Weld polishing
 - Deburring aircraft parts
 - Blending and finishing on a variety of metals, plastics, and composites

Scotch-Brite™ Light Deburring Wheels



Designed to provide a clean, safe and economical system for removing fine burrs while providing a highly polished finish.

Light Deburring wheels are one of the few wheel products that are offered in convolute form only, and are widely used for fine deburring and polishing because their conformability will maintain critical tolerances while still providing a fine polished finish.

Product Name	Density	Mineral Type	Grade
Light Deburring Wheel	6, 7, 8	Silicon Carbide	FIN

Diameters: 4" minimum 24" maximum
Widths: 6 density in 1/2"-36" 4"-12" diameters
 6 density in 3/4"-36" 12"-24" diameters
 7, 8 density in 3/8"-36" 4, 6, 8" diameters
 7, 8 density in 1/2"-36" 10, 12" diameters
 7, 8 density in 3/4"-36" 14"-24" diameters

- Typical applications:**
- Deburring of fine threads
 - Mold and die polishing
 - Finishing prior to buffing
 - Conditioning surface prior to welding on soft metals

Scotch-Brite™ SST Deburring Wheels



SST Deburring wheels are designed for deburring on stainless steel, titanium and other demanding alloys. Burrs from drilling, stamping, punching, and other machining operations can easily be removed with SST wheels.

Unlike some higher density products, SST wheels are somewhat softer and more conformable to suit work pieces with more intricate shapes and contours.

SST wheels are used extensively in the aerospace industry for deburring and finishing parts as well as finishing cast and threaded products used in medical and surgical applications.

See page 3 for convolute vs. unitized

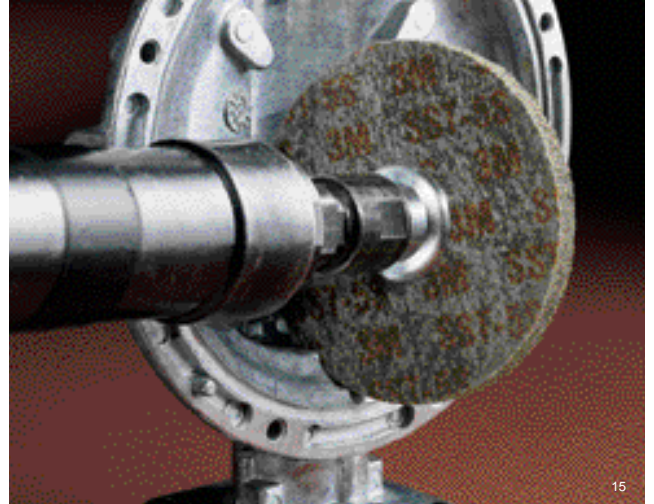
Product Name	Density	Mineral Type	Grade
SST Deburring Wheels	7	Aluminum Oxide	FIN
	8	Silicon Carbide	FIN

Diameters:	4" minimum	24" maximum
Widths:	3/8"-36" in 4", 6", 8" diameters 1/2"-36" in 10" and 12" diameters 3/4"-36" in 14"-24" diameters	

Typical applications:	<ul style="list-style-type: none"> • Deburring and finishing jet blades and vanes • OD polishing roller bearings • Polishing/blending of surgical instruments • Deburring of aluminum die cast flashing
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ SST Unitized Deburring Wheels



SST Deburring wheels offer the same deburring and finishing advantages as SST convolute wheels. The unitized version of the SST wheel is recommended when the application requires very narrow widths and/or small diameter ranges.

The wheels run well on bench motors and floor lathes as well as portable power tools.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
SST Unitized Wheel	3, 5, 7	Silicon Carbide	FIN
	3, 5, 7	Aluminum Oxide	FIN

Diameters:	1/2" minimum	14" maximum
Widths:	3 density in 1/4"-1" 5, 7 density in 1/8"-1" 1" maximum all diameters	

Typical applications:	<ul style="list-style-type: none"> • Deburring and finishing of aircraft engine components • Finishing of parts used in medical and surgical instruments • Mold and die polishing
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Cutting and Polishing Wheels



Heavy duty wheels for aggressive blending and finishing. Long lasting and aggressive, Cutting and Polishing wheels perform well on all kinds of tough blending and finishing jobs. They produce uniform results quickly and easily and are often used to replace conventional abrasives such as rubber bonded wheels, set-up wheels and abrasive flap wheels.

These wheels are excellent for removing defects, blending forging marks, removing coarse grindlines, blending machine mismatches, and providing uniform grain finish. Cutting and Polishing wheels have demonstrated value in a variety of applications for metal rod and tube surfaces and are especially well suited for centerless finishing.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
Cutting and Polishing Wheel	5	Aluminum Oxide	FIN
	7	Aluminum Oxide	VFN, FIN
			MED, CRS

Diameters: 4" Minimum 24" Maximum
Widths: 3/8"-36" in 4, 6, 8" diameters
 1/2"-36" in 10, 12" diameters
 3/4"-36" in 14"-24" diameters

- Typical applications:**
- Blending of abrasive grind lines
 - Centerless finishing machined parts
 - Conditioning of machined compressor shafts
 - Surface finishing of hand tools prior to plating

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Cutting and Polishing Unitized Wheels



Cutting and Polishing unitized wheels are long lasting and aggressive for heavy duty blending and finishing with uniform results. Layered "unitized" construction provides an excellent starting point for jobs requiring the availability of small diameters and narrow widths.

Cutting and Polishing unitized wheels can often be used to replace many conventional abrasive products such as rubber bonded wheels and small set up wheels.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
Cutting and Polishing	5	Aluminum Oxide	FIN
	7, 9	Aluminum Oxide	MED, CRS
Unitized Wheels	7, 9	Silicon Carbide	MED

Diameters: 1/2" minimum 14" maximum
Widths: 5, 7 density in 1/8", 1/4", 3/8", 1/2", 5/8", 3/4", 1"
 9 density in 1/8", 1/4", 3/8", 1/2"
 1" maximum all diameters

- Typical applications:**
- Parting line removal
 - Pipe thread deburring
 - Heavy-duty deburring of aerospace components

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Metal Finishing Wheels



Metal Finishing Wheels are a highly conformable products that provide uniform and consistent satin/antique finishes.

Metal Finishing wheels are used effectively to blend and match #3 or #4 mill finishes on stainless steel and to create brushed or satin finishes on cutlery. On softer metals such as aluminum, copper and brass they are used to blend out minor surface imperfections and handling marks as well as provide the desired decorative finish.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
Metal Finishing Wheel	4, 5, 6	Aluminum Oxide	CRS
	4, 5, 6	Aluminum Oxide	MED

Diameters:	4" minimum	18" maximum
Widths:	3/4"-36" 4 density in 4"-18" diameters	
	1/2"-36" 5, 6 density in 4"-12" diameters	
	3/4"-36" 5, 6 density in 14"-18" diameters	

Typical applications:	<ul style="list-style-type: none"> • Stainless steel blending and finishing • Finishing of aluminum molding • Satin finishing of builders hardware • Satin finishing of cutlery
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Metal Finishing Unitized Wheels



Offering the same unique finishing capability of Metal Finishing convolute wheels in small diameters and narrow widths.

Metal Finishing unitized provides durability and value for finishing of parts that are too narrow, tight or small to finish efficiently with wider width wheels.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
Metal Finishing Unitized	5	Aluminum Oxide	MED
	6	Aluminum Oxide	CRS

Diameters:	1" minimum	14" maximum
Widths:	1/4", 3/8", 1/2", 1"	
	1" maximum all diameters	

Typical applications:	<ul style="list-style-type: none"> • Weld cleaning and blending in stainless steel tank • Manufacturing finishing of builders hardware • Finishing/blending builders hardware • Finishing prior to buffing
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Multi-Finishing Wheels



Multi-Finishing wheels are highly conformable, soft wheels that create uniform and attractive final finishes on ferrous and non-ferrous metals. They are tough enough to finish edges and welds and soft enough to final finish large surfaces.

The open web construction of these wheels removes surface contamination and dirt while it resists surface loading and does not re-deposit contaminants onto the work piece. Silicon Carbide mineral offers a unique bright surface that is often desired by stainless steel fabricators.

Product Name	Density	Mineral Type	Grade
Multi-Finishing	2	Silicon Carbide	FIN
	2	Silicon Carbide	MED
	2	Silicon Carbide	CRS

Diameters: 4" minimum 16" maximum

Widths: 1"-36" in 4"-16" diameters

- Typical applications:**
- Cleaning of composite parts
 - Final finish of aluminum extrusions stainless steel
 - Finishing/blending
 - Finishing aircraft components

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Buff and Polish Wheels



Buff and Polish wheels are a unitized constructed, non-abrasive carrier for compounds used for polishing flat and symmetrically contoured surfaces. Often replacing felt or leather wheels, the Buff and Polish hold more compound with more even distribution allowing for faster cut and less frequent compound application.

Some typical industries applications where these wheels are of value are for fine jewelry, surgical instruments, fiber optic ends, medical implants and for honing and deburring knife edges.

Product Name	Density	Mineral Type	Grade
Buff and Polish	3, 5, 7	N/A	N/A Use with compound

Diameters: 1/2" minimum 14" maximum

Widths: 1/8"-1"
1" maximum all diameters

- Typical applications:**
- Jewelry polishing
 - Surgical instruments
 - Honing and deburring of knife edges
 - Fiber optic ends
 - Medical instruments

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ General Purpose Wheels



General Purpose wheels offer the greatest selection of grades, densities and mineral types. They are an excellent starting point when the application calls for fine finishing or cleaning.

General Purpose wheels are easier to use than buffs and compounds and other finishing abrasives and like all Scotch-Brite products, they produce consistent results.

See page 3 for convolute vs. unitized

Product Name	Density	Mineral Type	Grade
General Purpose	4,5,6	Aluminum Oxide	VFN
	4,5,6	Aluminum Oxide	FIN
	4,5,6	Aluminum Oxide	MED
	4,5,6	Silicon Carbide	ULF
	4,5,6	Silicon Carbide	SFN
	4,5,6	Silicon Carbide	VFN
	4,5,6	Silicon Carbide	FIN
	4,5,6	Silicon Carbide	MED
	4,5,6	Silicon Carbide	MED

Diameters:	4" minimum	24" maximum
Widths:	3/4"-24" 4 density in 4"-24" diameters 3/8"-24" 5, 6 density in 4, 6, 8" diameters 1/2"-24" 5, 6 density in 10, 12" diameters 3/4"-24" 5, 6 density in 14"-24" diameters	

Typical Applications:	<ul style="list-style-type: none"> • Polishing jewelry prior to plating • Selective polish on nameplates • Polish bevel edge of furniture glass • Light oxide removal
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ General Purpose Unitized Wheels



Much like General Purpose convolute wheels, this unitized product offers a wide selection of grades and densities. Designed for applications requiring fine finishes or light cleaning, General Purpose unitized wheels are always a good starting point when the part shape or size calls for small diameters or narrow width product.

See page 3 for convolute vs. unitized

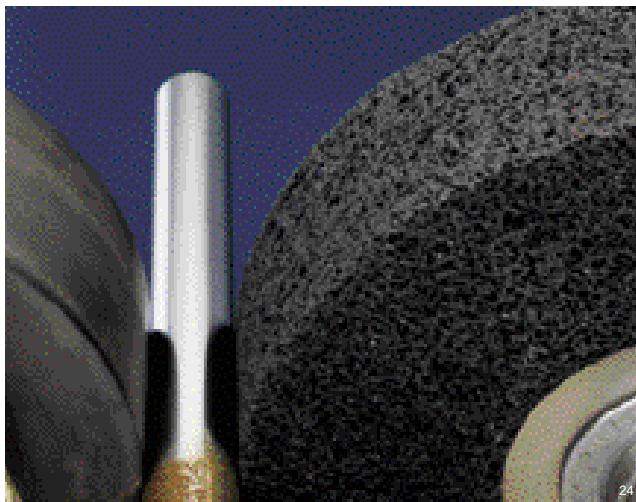
Product Name	Density	Mineral Type	Grade
General Purpose	3, 5, 7	Silicon Carbide	ULF
Unitized Wheels	3, 5, 7	Silicon Carbide	SFN
	3, 5, 7	Aluminum Oxide and Silicon Carbide	VFN
	3, 5, 7	Aluminum Oxide and Silicon Carbide	FIN
	3, 5, 7	Aluminum Oxide and Silicon Carbide	MED
	3, 5, 7	Aluminum Oxide	CRS

Diameters:	1/2" minimum	14" maximum
Widths:	1/4", 3/8", 1/2", 5/8", 3/4", 1" 1" maximum all diameters	

Typical applications:	<ul style="list-style-type: none"> • Fine thread polishing • Mold polishing • Jewelry polishing • Polishing turbine blades
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See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Clean & Strip Rim Wheels



An extra coarse web in a layered construction makes this Scotch-Brite™ Clean & Strip wheel a perfect choice for the removal of rust, oxides and light scale. The clean and strip wheel should also be considered for applications requiring a bright, coarse grain finish.

These wheels adapt to a broad range of equipment including bench grinders and automatic finishing equipment.

Product Name	Density	Mineral Type	Grade
Clean & Strip Rim Wheel	7	Silicon Carbide	XCS

Diameters: 8" minimum 16" maximum

Widths: 1"-4" in 8"-16" diameters

- Typical applications:**
- Coarse grain finishing
 - Centerless finishing
 - Rust removal
 - Light coating removal

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Clean & Strip Unitized Wheels and Cup Wheels



An extra coarse web material is converted into a variety of versatile Scotch-Brite™ Clean & Strip wheel products that provide an excellent tool for heavy duty cleaning applications.

The extra coarse silicon carbide mineral combined with tough synthetic web is perfect for removing scale, rust, surface contaminants, paints and coatings. These wheels are well suited for removing weld discoloration and splatter.

The open construction and aggressive properties provide a smooth running wheel that resists loading even when removing soft coatings.

Product Name	Density	Mineral Type	Grade
Clean & Strip Unitized Wheel	7	Silicon Carbide	XCS
Clean & Strip Cup Wheel	7	Silicon Carbide	XCS

Diameters: 1"-14" (Unitized) **Widths:** 1/4"-1" (Unitized)

Diameters: (Cup):
 3" 3/8"-24
 4" 1/2"-13
 4" 5/8"-11
 4" M-14
 4" M-10 x 1.25
 4" M-10 x 1.50
 4" 3/8"-24
 6" 7/8"-CH

- Typical applications:**
- Rust removal
 - Coating removal
 - Gasket removal
 - Light scale removal
 - Bright finishing - coarse scratch pattern

See pages 21-23 for recommended flanges/accessories

Scotch-Brite™ Woodworking Wheels



This wheel is a custom designed non-woven abrasive product for use on white wood sanding. The open construction and the use of garnet mineral reduces the potential for part burning. May be used in its straight form or shaped to various profiles.

Product Name	Density	Mineral Type	Grade
Woodworking Wheel	5	Garnet	MED

Diameters:	6" minimum	8" maximum
Widths:	3/4" minimum	36" maximum

Typical applications:

- Profile sanding
- Defuzzing

See pages 21-23 for recommended flanges/accessories

3M™ DLG Wheels



Tough, sharp, molded construction. Designed to remove pullouts and sharper marks on hardwood, softwood, particle board and fibre board shaped edges and moldings.

Easily shaped to conform to the molding profile with excellent retention of shape.

Product Name	Density	Mineral Type	Grade
DLG Finishing Wheel	soft, medium, hard	Garnet	120, 80, 60, 40

Diameters:	4", 6", 8"
Widths:	2" in 4" diameter 3/4"-3" in 6" diameter 3/4"-3" in 8" diameter

Typical applications:

- Fibre/particle board sanding of profiles and edges
- Edge sanding of picture frames and moldings
- Sanding out sharper marks

See pages 21-23 for recommended flanges/accessories

Factors Affecting Performance

Product Surface Speed

Because product speed has a significant effect on performance (cut, life, and finish), it is important to select the proper speed for a particular operation and work piece.

Generally, low speeds are desired for generating very uniform satin finishes, for finishing aluminum alloys without lubricants, and for use on composite or other soft material applications. High speeds are recommended when it is desired to remove or blend surface imperfections. This high speed will result in faster cut along with finer finishes.

Recommended Operating Speeds

Decorative Finishing	500-3000 SFPM
Composites/Soft Materials	1200-2700 SFPM
Cleaning and Conditioning	2000-5000 SFPM
Prepolishing	2000-7000 SFPM
Oxide Removal	4500-6500 SFPM
Deburring	5000-6500 SFPM
Blending / Polishing	6000-8000 SFPM
Cutdown prior to buffing	7000-8500 SFPM

Lubricant– Coolant

Coolants, like water and some water soluble oils, reduce heat resulting in longer product life and greater cut. In the case of most oils or tallow lubricants, surface roughness can be reduced. The higher viscosity lubricants produce lower surface roughness, i.e., grease produces a finer surface finish than oil. In automatic or semi-automatic operations, it is desirable to use lubricants or coolants whenever possible.

Product Hardness (Density)

3M™ wheels are available in a number of densities or hardnesses. Generally, the softer products, 2, 3, 4, and 5 density, are used for decorative finishing. They will conform more readily to surface contours along with generating a more uniform finish. The harder products, 6, 7, 8, and 9 density, are to be used for the more difficult blending, cleaning and deburring operations.

Surface Speed Conversion Chart

RPM at Arbor or Spindle	Diameter of Wheels								
	2	4	6	8	10	12	14	16	18
Surface Speed in Feet Per Minute (SSPM)									
100	52	104	157	207	260	314	364	419	471
200	105	208	314	414	520	628	728	838	942
300	157	312	471	621	780	942	1092	1257	1414
400	209	416	628	828	1040	1256	1456	1676	1885
500	262	520	785	1045	1310	1570	1820	2094	2356
600	314	630	940	1255	1570	1885	2195	2513	2827
700	367	735	1100	1465	1835	2200	2560	2932	3299
800	419	837	1256	1675	2094	2513	2932	3351	3770
900	471	942	1413	1885	2356	2827	3298	3770	4241
1000	524	1047	1570	2094	2618	3141	3665	4189	4712
1100	576	1152	1727	2304	2880	3455	4031	4608	5184
1200	628	1256	1884	2513	3142	3769	4398	5027	5655
1300	681	1361	2042	2723	3404	4084	4764	5445	6126
1400	733	1466	2199	2932	3666	4398	5131	5864	6597
1500	785	1571	2356	3142	3927	4712	5497	6283	7069
1600	838	1675	2513	3351	4189	5026	5864	6702	7540
1700	890	1780	2670	3560	4451	5340	6230	7121	8011
1800	942	1885	2827	3770	4713	5650	6597	7540	8482
1900	995	1989	2984	3979	4975	5969	6963	7959	8954
2000	1047	2094	3141	4189	5236	6283	7330	8378	9425
2100	1100	2199	3298	4398	5498	6497	7696	8796	9896
2200	1152	2304	3455	4608	5760	6911	8063	9215	10367
2300	1204	2408	3612	4817	6022	7225	8429	9634	10839
2400	1257	2513	3770	5027	6284	7540	8796	10053	11310
2500	1309	2618	3927	5236	6545	7854	9162	10472	11781
2600	1361	2722	4084	5445	6807	8168	9529	10891	12252
2700	1414	2827	4241	5655	7069	8482	9895	11310	12723
2800	1466	2932	4398	5864	7331	8796	10262	11729	13195
2900	1518	3037	4555	6074	7592	9110	10629	12148	13666
3000	1571	3141	4712	6283	7854	9425	10996	12566	14137
3200	1676	3351	5026	6702	8378	10053	11729	13404	15080
3400	1780	3560	5340	7121	8901	10681	12462	14242	16022
3600	1885	3769	5654	7539	9425	11309	13193	15080	16965
3800	1990	3979	5969	7958	9948	11938	13927	15917	17907
4000	2094	4188	6283	8377	10472	12566	14661	16755	18850

Convolute Wheels

Maximum Operating Speeds (RPM)

Diameter	All Wheels (rpm)	Diameter	All Wheels (rpm)
4"	9,000	14"	2,550
6"	6,000	16"	2,250
8"	4,500	18"	2,000
10"	3,600	20"	1,800
12"	3,000	24"	1,500

Ordering Instructions

Specify product code or product name, mineral type, grade, and size: diameter x width x core size.

Example:

Scotch-Brite™ EXL Deburring Wheel, 8S FIN, 8" x 1" x 3"

or

XL-WL, 8S FIN, 8" X 1" X 3"

or

048011-12345-6

Unitized Wheels

Maximum Operating Speeds (RPM)

Size (Diameter x Width)	BP-UW	CS-UW	CP-UW	XL-UW 2S, 3S	XL-UW 2A, 4A XCS	XL-UW 4,6,8 Except 4A XCS	GP-UW	ST-UW 3	ST-UW 5, 7	MF-UW
Less than 1"	40,100	40,100	40,100	35,100	30,100	40,100	35,100	40,100	40,100	--
1" x All	35,100	35,100	35,100	30,100	25,100	35,100	30,100	35,100	35,100	35,100
1½" x All	30,100	25,100	30,100	20,100	18,100	30,100	20,100	25,100	30,100	25,100
2" x ¼"-½"	24,100	20,100	22,100	16,100	16,100	22,100	16,100	20,100	22,100	18,100
2" x ¾"-1"	24,100	20,100	22,100	16,100	14,100	22,100	16,100	18,100	22,100	18,100
2½" x ⅛"	22,100	--	20,100	--	--	20,100	12,500	--	20,100	15,100
2½" x ¼"	22,100	16,100	20,100*	14,100	14,100	20,100	12,500	18,100	20,100	15,100
2½" x ⅜"	22,100	16,100	20,100	14,100	12,100	20,100	12,500	18,100	20,100	15,100
2½" x ½"	22,100	16,100	18,100*	14,100	12,100	18,100*	12,500	18,100	18,100	15,100
2½" x ¾"-1"	22,100	16,100	18,100*	12,500	10,000	18,100	12,500	15,100	18,100	15,100
3" x ⅛"	18,100	--	18,100	--	--	18,100	10,000	--	18,100	12,500
3" x ¼"	18,100	14,100*	18,100	12,100	12,100	18,100	10,000*	14,100	18,100	12,500
3" x ⅜"	18,100	14,100	18,100	12,100	10,000	18,100	10,000	14,100	18,100	12,500
3" x ½"	18,100	18,100	15,100*	10,000	10,000	15,100*	10,000*	14,100	15,100*	12,500
3" x ¾"-1"	18,100	14,100	15,100*	10,000	9,000	15,100	10,000*	12,500	15,100	12,500
4" x ⅛"-½"	14,100	10,000	12,100	8,500	8,000	12,100	8,000	10,000	12,100	9,000
4" x ¾"-1"	14,100	10,000	12,100	8,000	7,000	12,100	8,000	9,000	12,100	9,000
5" x All	12,100	8,000	9,000	6,000	5,500	9,000	6,000	7,500	9,000	7,500
6" x All	10,000	7,000	7,500	5,000	4,500	7,500	5,000	6,000	7,500	6,000
7" x All	8,000	6,000	6,000	4,500	4,000	6,000	4,500	5,000	6,000	5,000
8" x All	7,000	5,000	5,500	4,000	3,500	5,500	4,000	4,500	5,500	4,500
9" x All	6,000	4,500	5,000	3,500	3,000	5,000	3,500	4,000	5,000	4,000
10" x All	5,000	4,200	4,500	3,200	2,800	4,500	3,200	3,750	4,500	3,750
11" x All	4,500	3,800	4,000	2,900	2,500	4,000	2,900	3,400	4,000	3,400
12" x All	4,000	3,500	3,750	2,600	2,300	3,750	2,600	3,100	3,750	3,100
13" x All	3,500	3,200	3,450	2,400	2,100	3,450	2,400	2,800	3,450	2,800
14" x All	3,200	3,000	3,200	2,200	2,000	3,200	2,200	2,650	3,200	2,650
15" x All	3,000	--	--	--	--	--	--	--	--	--
16" x All	2,800	--	--	--	--	--	--	--	--	--
17" x All	2,600	--	--	--	--	--	--	--	--	--
18" x All	2,500	--	--	--	--	--	--	--	--	--
19" x All	2,300	--	--	--	--	--	--	--	--	--
20" x All	2,250	--	--	--	--	--	--	--	--	--

*Means "Dual" rating – product has a higher MOS also.

UW= Unitized Wheel
 BP = Buff and polish
 CS = Clean and Strip
 CP = Cut and Polish

XL = EXL
 GP = General Purpose
 ST = SST
 MF= Metal Finishing

Unitized Wheels

Maximum Operating Speeds (RPM) (Continued)

The following Unitized Wheels (in either 1/4" or 3/8" I.D.) have been certified to run at higher maximum operating speeds when using the following hardware (or their equivalents) – #990 or #991 Mandrel – or used with 1"-1/2" OD and 3/8" ID flat washers.

Product
18,100 RPM
Clean & Strip Unitized Wheel 7S XCS 3x/4
Cutting and Polish Unitized Wheel 5A FIN 3x/4
Cutting and Polish Unitized Wheel 5A FIN 3x/4
Cutting and Polish Unitized Wheel 7A MED 3x/4
Cutting and Polish Unitized Wheel 7A MED 3x/4
Cutting and Polish Unitized Wheel 7S MED 3x/4
Cutting and Polish Unitized Wheel 7S MED 3x/4
Cutting and Polish Unitized Wheel 7A CRS 3x/4
EXL Unitized Wheel 4A FIN 3x/4
EXL Unitized Wheel 4S FIN 3x/4
EXL Unitized Wheel 6A FIN 3x/4
EXL Unitized Wheel 6S FIN 3x/4
EXL Unitized Wheel 6A MED 3x/4
EXL Unitized Wheel 8A MED 3x/4
EXL Unitized Wheel 8A CRS 3x/4
General Purpose Unitized Wheel 5A MED 3x/4
General Purpose Unitized Wheel 5A MED 3x/4
General Purpose Unitized Wheel 5A FIN 3x/4
General Purpose Unitized Wheel 5A FIN 3x/4
General Purpose Unitized Wheel 7A FIN 3x/4
General Purpose Unitized Wheel 7A FIN 3x/4
General Purpose Unitized Wheel 7S FIN 3x/4
General Purpose Unitized Wheel 7S FIN 3x/4
SST Unitized Wheel 5S FIN 3x/4
SST Unitized Wheel 7S FIN 3x/4

20,100 RPM
EXL Unitized Wheel 6A MED 2 1/2x1/2
EXL Unitized Wheel 8A MED 2 1/2x1/2
22,100 RPM
Cutting and Polish Unitized Wheel 5A FIN 2 1/2x1/2
Cutting and Polish Unitized Wheel 5A FIN 2 1/2x1/2
Cutting and Polish Unitized Wheel 7A MED 2 1/2x1/2
Cutting and Polish Unitized Wheel 7A MED 2 1/2x1/2
Cutting and Polish Unitized Wheel 7S MED 2 1/2x1/2
Cutting and Polish Unitized Wheel 7S MED 2 1/2x1/2

Cup Wheels	RPM
Clean & Strip Cup Wheel 6" diameter	7,000 RPM
Clean & Strip Cup Wheel 4" diameter	12,100 RPM
Clean & Strip Cup Wheel 3" diameter	18,100 RPM



Convolute Wheels

Accessories

3M™ Flanges (FL-AC)

Catalog Number	Used With	Diameter x CH	Pairs Per Case
3	1" CH Wheels	1"x 3/8" 1"x 1/2" 1"x 5/8" 1"x 3/4" 1"x 7/8"	1 1 1 1 1
4	1/4" CH Wheels	1/4"x 3/8" 1/4"x 1/2" 1/4"x 5/8" 1/4"x 3/4" 1/4"x 7/8" 1/4"x 1"	1 1 1 1 1 1
5	1/2" Wide x 1" CH or 1" Wide x 1 CH Wheels <i>Note: Telescoping wheel adaptors 1" and 1/2" wide are used to reduce 1" wheel center holes to fit 1/2", 5/8", 3/4" or 7/8" shafts.</i>	1" x 1/2" x 1/2" 1" x 1" x 1/2"	1 1
355	3" CH Wheels when a protruding locking nut is not desirable	3"x 1/2" 3"x 3/8"	1 1
356	3" CH Wheels	3"x 1/2" 3"x 3/8" 3"x 3/4" 3"x 7/8" 3"x 1" 3"x 1 1/4" 3"x 1 1/2"	1 1 1 1 1 1 1
356	4" CH Wheels	4"x 1/2" 4"x 5/8" 4"x 3/4" 4"x 1" 4"x 1 1/4"	1 1 1 1 1
356	5" CH Wheels	5"x 3/4" 5"x 7/8" 5"x 1" 5"x 1 1/4" 5"x 1 1/2" 5"x 1 3/4" 5"x 2"	1 1 1 1 1 1 1
356	8" CH Wheels	8"x 1" 8"x 1 1/4" 8"x 1 1/2" 8"x 1 3/4" 8"x 2"	1 1 1 1 1
356	10" CH Wheels	10"x 1 1/4" 10"x 1 1/2" 10"x 1 3/4" 10"x 2"	1 1 1 1
356	12" CH Wheels	12"x 1 1/4" 12"x 1 1/2"	1 1

Wheels

Accessories

3M™ Flanges (FL-AC) (Continued)

Catalog Number	Used With	Diameter x CH	Pairs Per Case
365	½" Wide 3" CH Wheels	3"x½"	1
		3"x⅝"	1
		3"x¾"	1
		3"x⅞"	1
		3"x1"	1
		3"x1¼"	1
365	½" Wide 5" CH Wheels	5"x¾"	1
		5"x⅞"	1
		5"x1"	1
		5"x1¼"	1
		5"x1½"	1
		5"x1¾"	1
		5"x2"	1
468	1¼" CH DLG Wheels	2 ² / ₃ " x ⅝"	1

Other sizes available on special request

3M Dressing and Shaping Products (DS-AC)

Product	Used To	Contents	Pkg.
320 3M Wheel Shaping Kit	Dress and shape Woodworking Wheels	1 Roll 2"x30' THREE-M-ITE Resin Bond PSA Abrasive Grade 40 1 Roll 2"x30' Conformable Shaping Tape Grade 80	1
#40 THREE-M-ITE Resin Bond Cloth PSA 2"x 50 yards	Dress wheels and rough shape contours into wheels where more conformability is required	1 Roll #40 Resin Bond Cloth PSA 2" x 50 yards	1
#80 Conformable Shaping Tape 2"x 50 yards	Final dress wheels and finely shape contours into wheels	1 Roll #80 3M conformable shaping tape 2" x 50 yards	1
Wide Brush and Wheel Dressing Material	Dress wide brushes and wheels	1 Sheet 18"x72" THREE-M-ITE Resin Bond PSA Abrasive Grade 36	1
54 Pumice Block	Dress wheels	12 Blocks Pumice 2 x¾" x 2¼" x 5¼"	12
Hand Dresser Tool	Regenerate cutting surface. Removing oils and greases from wheels	1 Ea. Hand Dresser Tool	1

Unitized Wheels

Accessories

3M™ Mandrels (MN-AC)

Catalog Number	Use With Unitized wheels	Overall Length x Shank Size x Washer Dia.	Maximum Operating RPM	Mandrels Per Case
931	1, 1½" diameter x ¼" wide x ⅛" CH	1½" x ⅜" x ½"	13,000	5
932	1½, 2" diameter x ¼", ½" wide x ¼" CH Note: ⅜" CH is recommended for wheels 6 density and harder.	2" x ¼" x ⅜"	20,000	5
933	2, 2½"-3" diameter x ¼", ½", ¾", 1" wide x ¼" CH Note: ⅜" CH is recommended for wheels 6 density and harder.	2" x ¼" x 1"	14,000	5
934	3"-6" diameter x ¼", ½", ¾", 1" wide x ½" CH	3⅜" x ¼" x 2½"	12,000 w/3" dia 8,500 w/4" dia 6,000 w/6" dia	1
936 (plastic)	1" diameter x 1" wide x ⅜" CH	2⅜" x ¼" x ¾"	22,200	5
946 (steel)	1" diameter x 1" wide x ⅜" CH	1¾" x ¼" x ½" Hex Nut Dia.	35,200	5
990	2"-3" diameter x ⅛"-½" wide x ⅜" CH	1¾" x ¼"	25,100 w/2" dia 22,100 w/2½" dia 18,100 w/3" dia	5
991	2"-3" diameter x ¾"- 1" wide x ⅜" CH	1⅞" x ¼"	25,100 w/2" dia 22,100 w/2½" dia 18,100 w/3" dia	5
992	1"-1½" diameter x ⅜"- ½" wide x ⅜" CH	1½" x ⅞"	35,200 w/1" dia 30,200 w/1½" dia	5
994	1"-1½" diameter x ⅜"- ½" wide x ⅜" CH	1½" x ¼"	35,200 w/1" dia 30,200 w/1½" dia	5
996	½"-¾" diameter x ⅜"- ¼" wide x ⅞" CH	1⅞" x ⅞"	40,200 w/½" & ¾" dia	5
998	½"-¾" diameter x ⅜"- ½" wide x ⅞" CH	1⅞" x ¼"	40,200 w/½" & ¾" dia	5

Convolute Wheel Diameters and Standard Core Sizes

Wheel Diameter	Standard Core Size
4"	1"
6"	1", 1 ¼"
8"	3"
10"	5"
12"	5"
14"	8"
16"	10"
18"	10"
20"	12"
24"	12"

For more information and assistance:

Contact your local 3M surface conditioning products distributor or 3M at the numbers listed below.

For the contiguous 48 United States

Call1-800-742-9546
Fax1-800-852-4668

For Alaska907-522-5200
Canada519-451-2500
Hawaii808-422-2721
Northern Mexico ...915-599-4685
Puerto Rico809-750-3000

IMPORTANT NOTICETO PURCHASER

Product Use: User is responsible for determining whether the product is fit for a particular purpose and suitable for user's application.

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Safety Information: Always use appropriate protective glasses, face shields and body protection. Do not exceed maximum operating RPM's. Use guards provided with machine. Follow safety operation procedures posted in work areas.

The foregoing Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of 3M.



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