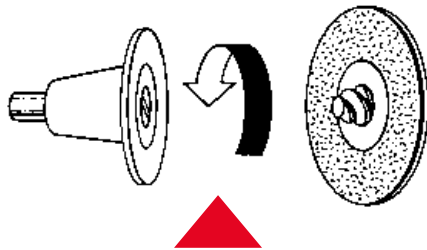


# What is Roloc™?

## The benefits of the Roloc™ attachment

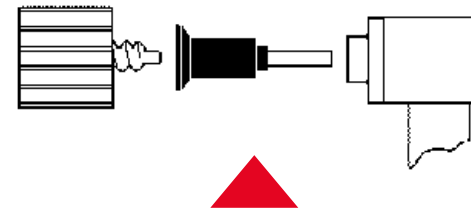
3M™ Roloc™ Abrasive Discs are smaller discs that quickly attach onto a Roloc™ disc pad so that you can conveniently and rapidly change discs as needed. Our system provides a secure attachment even for heavy-duty applications. Each disc is also color-coded to identify its grade, making it easy to select the grade required for different applications.

- ▶ Remote applications
- ▶ Retain extra control
- ▶ Localized, refining, finishing
- ▶ Corner or curved surfaces
- ▶ Intricate, difficult to reach areas
- ▶ Remove weld splatter on small areas



### 3M™ Roloc™ Quick Release System

- ▶ 3M™ Roloc™ discs are designed for use on the face of the disc
- ▶ Available in a range of products for grinding, finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ Back-Up Pad assures secure fixing with rapid grade or product change
- ▶ Can be used with 3M™ Roloc™ Rubber Back-Up Pad




### 3M™ Roloc™+ Quick Release System

- ▶ 3M™ Roloc™+ discs/brushes are designed for use on the edge and have a longer shaft for extra strength
- ▶ Available in a range of products for finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ plastic holder assures secure fixing with rapid grade or product change
- ▶ To be used with all 3M™ Roloc™+ plastic holders (excluding 3M™ Roloc™ rubber back-up pads)

### 3M™ Roloc™ Disc button color/grade chart


●	24+ grade/black
●	36+ grade/brown
●	50+ grade/green
●	60+ grade/orange
●	80+ grade/yellow
●	P100 grade/blue
○	P120 grade/white
●	P150 grade/black
●	P180 grade/brown
●	P240 grade/green
●	P320 grade/yellow
●	P400 grade/blue

### 3M™ Roloc™ Attachment System Guide




▶ **TR** – plastic button

Diameter	Attachment type		
	TR	TSM	TS
3/4"	◆		◆
1"	◆	◆	◆
1-1/2"	◆	◆	◆
2"	◆	◆	◆
3"	◆	◆	◆
4"	◆		◆



▶ **TSM** – metal button

Product ID	Attachment type		
	TR	TSM	TS
361F	◆	◆	
777F	◆	◆	◆
947A	◆	◆	
984F	◆	◆	
782C	◆	◆	
787C	◆	◆	
982C	◆	◆	
987C	◆	◆	



▶ **TS** – plastic button

### Optimum tool speeds to maximize 3M™ Roloc™ Disc cut rates and life

Disc size	Material			
	Stainless	Aluminum	Steel	Titanium
1-1/2"	20,000 RPM	30,000 RPM	30,000 RPM	9,000 RPM
2"	15,000 RPM	20,000 RPM	20,000 RPM	7,000 RPM
3"	10,000 RPM	15,000 RPM	15,000 RPM	4,500 RPM
4"	8,000 RPM	9,000 RPM	9,000 RPM	3,000 RPM

## Meet the

# Premium Series

of right angle abrasives **for unparalleled power and performance!**

Featuring 3M™ Cubitron™ II Abrasives for an unbeatable combination of speed and long life, and Scotch-Brite™ Abrasives for ease of use and consistent quality finishes.



## Introducing the

# Advanced Series

of right angle abrasives **for value-priced performance!**

The next-best thing to our Premium Series of 3M™ Cubitron™ II Abrasives, our new Advanced Series harnesses the power of 3M™ Precision-Shaped Ceramic Grain and helps minimize your abrasive spend.

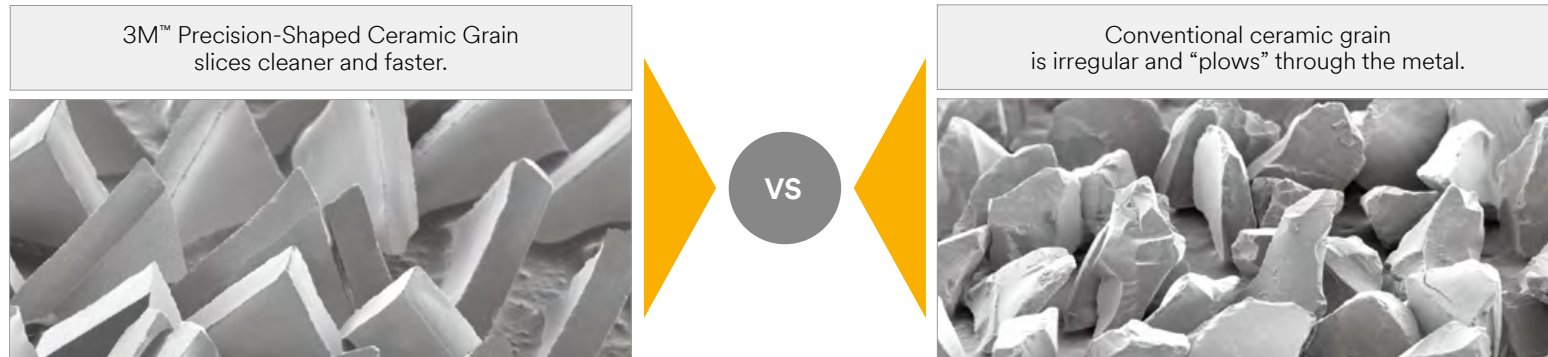


## Technology:

# CUBITRON™ II

3M™ Cubitron™ II Abrasives are revolutionizing the cutting and grinding process. They're faster-cutting and longer-lasting than conventional abrasives.

The secret lies in the revolutionary 3M™ Precision-Shaped Ceramic Grain technology. As the triangular-shaped grain wears, it continuously fractures to form sharp peaks that slice through metal – providing a cooler, faster and longer lasting cut.



- ✓ Cooler operation
- ✓ Clean cut
- ✓ Lasts much longer



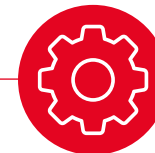
- ✗ Heat build-up
- ✗ Slower cutting
- ✗ Shorter life



Cuts faster



Works harder



Increases productivity

## Technology:

# Scotch-Brite™

### The perfect finish starts with Scotch-Brite™

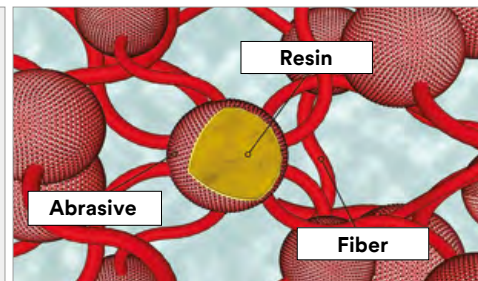
There's one family of abrasives that's trusted to deliver repeatable results and fine finishes, and it's Scotch-Brite. With roots in the past and an eye on the future, Scotch-Brite™ Industrial Abrasives are dedicated to uncompromising quality – just like you.

### Scotch-Brite Non-Woven technology explained

Our unique non-woven web is the secret to superior performance. It binds together synthetic fibers and abrasive particles to create a conformable, three-dimensional material. Its open structure reduces the risk of warping or discoloring the part, resists loading, improves finish and prolongs the product's life.

#### What makes Scotch-Brite the best you can buy?

- ▶ A tough, non-woven nylon web impregnated with resin and mineral throughout its structure
- ▶ Spring-like action produces a smooth, burr-free surface
- ▶ Uniform, consistent results with no undercutting
- ▶ Suitable for deburring, finishing, cleaning and small weld removal applications
- ▶ Easy to use, less rework, fewer rejects





# Application guide



















Application use:

## Premium Series

Designed for unparalleled power and performance



### Color key for navigating product sections:

-  = Grinding and stock removal
-  = Deburring
-  = Refining and finishing
-  = Contamination removal and cleaning
-  = Roloc+ range

Products:	Page #	Substrate use:	Grinding & stock removal	Deburring	Refining	Finishing	Cleaning	Contaminate removal
 3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	heavy	◆	◆	◆		
 3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum	medium			◆		
 3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel	medium/high	◆	◆			
 3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, non-ferrous metals, aluminum	medium/high	◆	◆			
 Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)	25	all metals		heavy		◆		
 Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)	26	metals, plastics, composites		moderate/heavy		◆		
 Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)	27	all metals		edge		◆		
 Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR)	30-31	aluminum, white metals				◆		
 Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)	32-33	all metals		◆	◆	◆	◆	
 Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)	34	all metals		light		◆		
 Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)	35	all metals		heavy	◆	◆	◆	
 Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	38	rust, coatings, weld discoloration					◆	heavy removal
 Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	39	heavy rust and rust pit removal without leaving divots			◆		◆	◆
 Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	40	all metals		◆		◆	◆	
 Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)	42	wood, metals, lacquers		light			◆	
 Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)	42	all metals		light		◆	◆	
 Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc	43	corrosion, coatings, metals			◆		◆	◆
 Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc	43	corrosion, coatings, metals					◆	heavy removal

## Advanced Series

Designed for value-priced performance

Products:	Page #	Substrate use:	Grinding & stock removal	Deburring	Refining	Finishing	Cleaning	Contaminate removal
 3M™ Roloc™ Fibre Disc 782C	17	mild steel	medium/high	◆	◆	◆		
 3M™ Roloc™ Fibre Disc 787C	18	stainless steel, non-ferrous metals, aluminum	medium/high	◆	◆	◆		
 3M™ Roloc™ Disc 777F	19-20	mild steel, stainless steel, non-ferrous metals, aluminum	medium			◆		
 3M™ Roloc™ Disc 361F	21-22	all metals			◆	◆	◆	◆

# Application guide continued from previous page >>>

## Application use:

### Premium Series

#### Products:

#### Page #

#### Substrate use:

#### Beveling

#### Weld prep

#### Weld removal

#### Blending





#### Rust removal

#### Paint prep

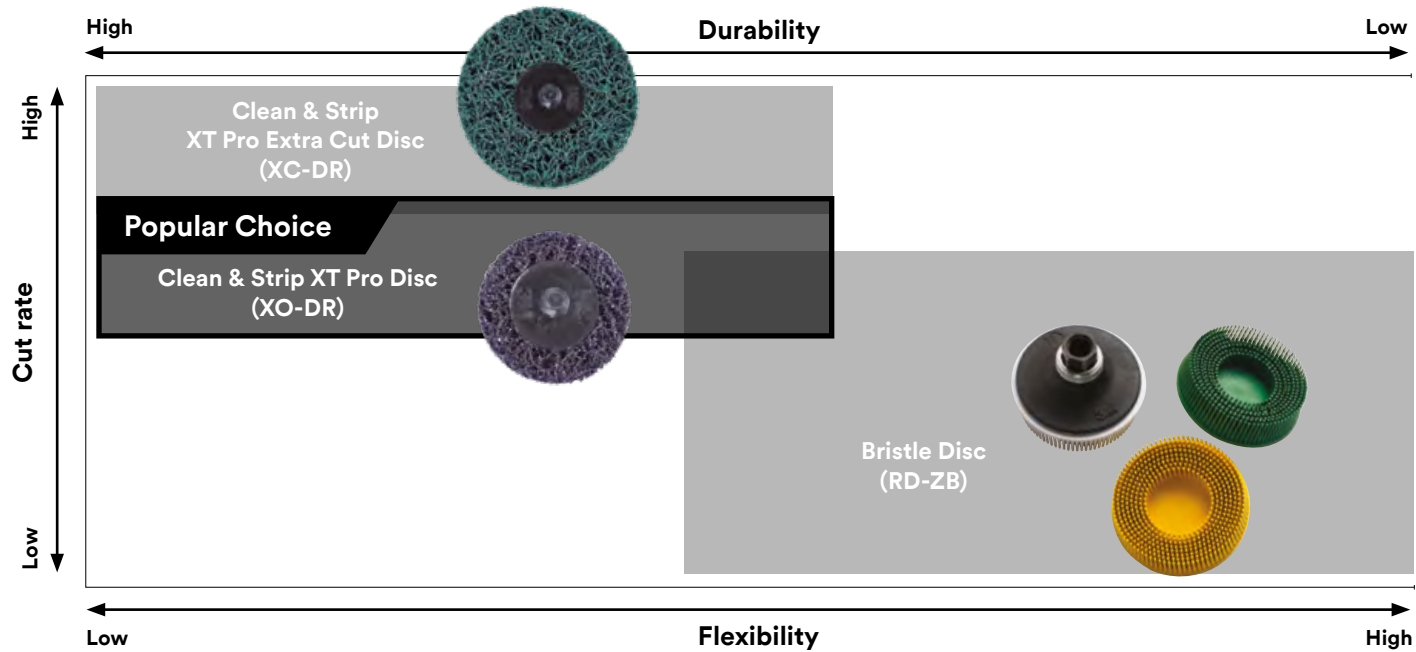
	3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	◆	◆	small welds	◆		
	3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum						
	3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel			small welds	◆		
	3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, non-ferrous metals, aluminum			small welds	◆		
	Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)	25	all metals				◆		
	Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)	26	metals, plastics, composites				weld blending		
	Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)	27	all metals				weld blending		
	Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR)	30-31	aluminum, white metals				◆		
	Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)	32-33	all metals				◆		◆
	Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)	34	all metals			small welds	◆		◆
	Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)	35	all metals						
	Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	38	rust, coatings, weld discoloration					◆	◆
	Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	39	heavy rust and rust pit removal without leaving divots					◆	◆
	Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	40	all metals				◆	◆	
	Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)	42	wood, metals, lacquers						
	Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)	42	all metals						
	Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc	43	corrosion, coatings, metals						
	Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc	43	corrosion, coatings, metals						

### Advanced Series

#### Products:

	3M™ Roloc™ Fibre Disc 782C	17	mild steel			small welds	◆		
	3M™ Roloc™ Fibre Disc 787C	18	stainless steel, non-ferrous metals, aluminum			small welds	◆		
	3M™ Roloc™ Disc 777F	19-20	mild steel, stainless steel, non-ferrous metals, aluminum				◆		
	3M™ Roloc™ Disc 361F	21-22	all metals					◆	

# Positioning | Contamination removal and cleaning



Product	Feature	Substrate	Application
Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)	Durable, conformable, highly resistant to loading, low spark, silicon carbide	All metals	Coating removal; surface prep; rust, paint, and light mill scale removal
Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)	Extended life, conformable, high speed rating, highly resistant to loading, aluminum oxide mineral, quick cut to bare metal, doesn't leave divots	All metals	Thick paint and coating removal; surface prep; heavy rust and rust pit removal; weld refinement; removing weld discoloration; adhesion prep
Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)	Ceramic and aluminum oxide blend, flexible bristles	All metals	Blending, finishing, polishing, cleaning



## Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)



### Feature:

Durable, conformable, highly resistant to loading, low spark, silicon carbide

### Backing:



Non-woven construction

### Application:

Heavy contamination removal, rust, coatings, weld discoloration

### Substrate:

All metals

UPC	Size dia. (inches) x ctr. hole	Grade	Disc color	Max. Speed (RPM)	Min./case
<b>Roloc™ TR</b> (plastic button) 					
638060-21538-8	2" x NH	S XCS	Purple	18,000	10/60
638060-21540-1	3" x NH	S XCS	Purple	15,000	10/cs
638060-21541-8	3" x NH	S XCS	Purple	15,000	10/40
638060-21542-5	4" x NH	S XCS	Purple	11,000	10/40
<b>Roloc™ TR+</b> (plastic button) 					
638060-21552-4	4" x 1/2"	S XCS	Purple	12,000	10/cs
638060-21549-4	4" x 1"	S XCS	Purple	8,000	10/cs

- ▶ Load-resistant material resists clogging for consistent cutting action
- ▶ Quickly removes rust, paint, adhesives and other coatings
- ▶ Smear-resistant properties avoid extra cleaning of the work surface
- ▶ Extra coarse (XCS) grade silicon carbide provides aggressive cutting and leaves a fine finish without gouging the workpiece

## Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)



**Feature:**

Extended life, conformable, high speed rating, highly resistant to loading, quick cut to bare metal

**Backing:**


Non-woven construction

**Application:**

Rust removal, thick paint and coating removal, weld refinement, adhesion prep

**Substrate:**

All metals

UPC	Size dia. (inches) x ctr. hole	Grade	Disc color	Max. speed (RPM)	Min./case
<b>Roloc™ TR (Plastic Button)</b> 					
638060-21543-2	2" x NH	A XCS	Green	18,000	10/60
638060-21544-9	3" x NH	A XCS	Green	15,000	10/cs
638060-21545-6	3" x NH	A XCS	Green	15,000	10/40
638060-21546-3	4" x NH	A XCS	Green	11,000	10/40

- ▶ Removes heavy rust and rust pits without leaving divots
- ▶ Aluminum oxide provides a more aggressive cut versus Scotch-Brite™ Roloc™ Clean & Strip XT Pro
- ▶ Load-resistant material resists clogging for consistent cutting action
- ▶ Ideal for weld refinement and removing weld discoloration
- ▶ This unique disc can aggressively clean without significantly altering the base material

## Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)



**Feature:**  
Ceramic and aluminum oxide blend, flexible bristles

**Backing:**  
Molded, flexible bristles

**Application:**  
Strip, deburr, blend, finish, polish, clean

**Substrate:**  
All metals



UPC	Size diameter (inches)	Grade	Disc color	Max. speed (RPM)	Min./case
<b>Roloc™ TR</b> (plastic button) 					
048011-18698-6	1"	50	Green	30,000	80/cs
048011-18706-8	1"	80	Yellow	30,000	80/cs
048011-18710-5	1"	120	White	30,000	20/80
048011-18730-3	2"	50	Green	25,000	10/40
048011-18732-7	2"	80	Yellow	25,000	10/40
048011-18733-4	2"	120	White	25,000	10/40
048011-18734-1	3"	50	Green	15,000	10/40
048011-18736-5	3"	80	Yellow	15,000	10/40
048011-18737-2	3"	120	White	15,000	10/40

- ▶ Our fast-running disc combines superior cutting action and increased ability to conform with the 3M™ Roloc™ quick change attachment system
- ▶ Efficiently clean, strip, deburr, blend, finish, polish, scratch and remove rust and coatings while maintaining the base product geometry
- ▶ For increased performance, Scotch-Brite™ Bristle Discs feature aluminum oxide blended with ceramic abrasive grain for one of the hardest, longest-lasting minerals available