

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



TSM – metal button



TS – plastic button

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

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

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

Application guide

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:	Application 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:	Application 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

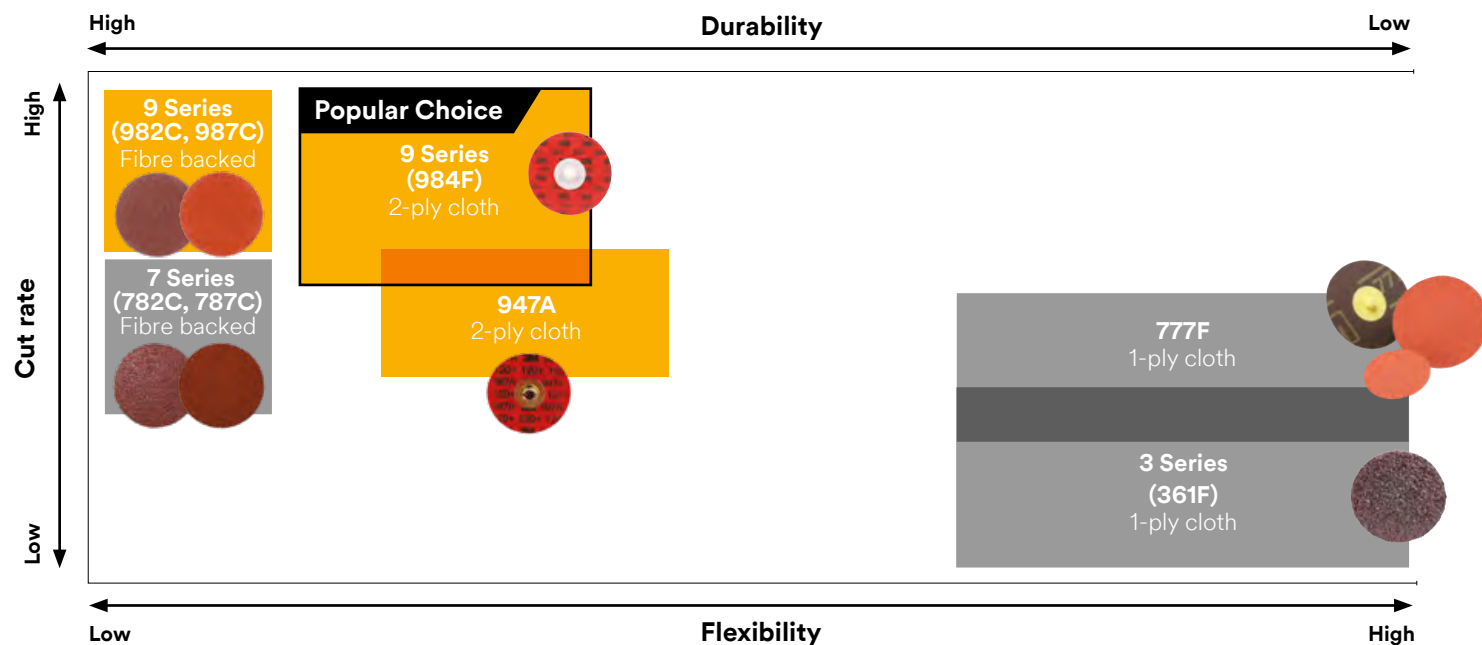
	3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	◆	◆	small welds	◆		
	3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum						
	3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel			small welds	◆		
	3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, 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 | Grinding and stock removal



Please note: Back-up pad affects disc performance

Premium Series Products:

	Feature	Substrate	Application
3M™ Cubitron™ II Roloc™ Fibre Disc 982C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, refining, deburring, small beveling
3M™ Cubitron™ II Roloc™ Fibre Disc 987C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Cubitron™ II Roloc™ Durable Edge Disc 984F	3M™ Precision-Shaped Ceramic Grain, durable edge, grinding aid	Mild steel, stainless steel	Beveling, weld prep, small weld removal, blending, finishing, refining, deburring
3M™ Cubitron™ II Roloc™ Durable Edge Disc 947A	3M™ Precision-Shaped Ceramic Grain blend, durable edge, grinding aid	Mild steel, stainless steel, aluminum	Works for lighter applications than 984F due to the blend of 3M™ Precision-Shaped Ceramic Grain and conventional grain

Advanced Series Products:

3M™ Roloc™ Fibre Disc 782C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, finishing, refining, deburring, small beveling
3M™ Roloc™ Fibre Disc 787C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Roloc™ Disc 777F	Ceramic and aluminum oxide blend, grinding aid	Mild steel, stainless steel, non-ferrous metals, aluminum	Medium stock removal, grinding, blending
3M™ Roloc™ Disc 361F	Aluminum oxide, good grade range	All metals	General purpose applications, rust removal, cleaning, contaminate removal, finishing, refining

3M™ Roloc™ Fibre Disc 787C

Advanced Series

for value-priced performance



Feature:

3M™ Precision-Shaped Ceramic Grain, grinding aid

Backing:

Fibre backing

Application:

Medium/high stock removal, medium/low pressure

Substrate:

Stainless steel, non-ferrous metals, aluminum

- ▶ Engineered for ultra-rapid cut, 3M™ Roloc™ Fibre Disc 787C features precision-shaped ceramic grain
- ▶ Cuts cooler, faster and lasts longer than alumina zirconia (AZ) and conventional ceramic discs in applications like weld removal, beveling, edge chamfering and more
- ▶ Constructed with a grinding aid, it is an excellent choice for weld removal, blending and finish refinement on stainless steel and high nickel alloys

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
076308-89689-8	2"	36+	Brown	25,000	50/200
076308-89694-2	2"	60+	Orange	25,000	50/200
076308-89699-7	2"	80+	Yellow	25,000	50/200
076308-89704-8	2"	120+	White	25,000	50/200
076308-89690-4	3"	36+	Brown	20,000	50/200
076308-89695-9	3"	60+	Orange	20,000	50/200
076308-89700-0	3"	80+	Yellow	20,000	50/200
076308-89705-5	3"	120+	White	20,000	50/200
076308-89691-1	4"	36+	Brown	12,000	25/100
076308-89696-6	4"	60+	Orange	12,000	25/100
076308-89701-7	4"	80+	Yellow	12,000	25/100
076308-89706-2	4"	120+	White	12,000	25/100
Roloc™ TS (Plastic Button) 					
076308-89709-3	4"	36+	Brown	12,000	25/100
076308-89710-9	4"	60+	Orange	12,000	25/100
076308-89711-6	4"	80+	Yellow	12,000	25/100
076308-89712-3	4"	120+	White	12,000	25/100