






3M™ Stainless Steel Finishing System

Discover how fast and effective 3M abrasives can be for the often difficult task of stainless steel weld removal and finishing. This 3-step system features our Scotch-Brite™, Cubitron™ II and Trizact™ abrasives.

In three easy steps, using the 3M Finishing System, you can grind and blend welds to match your finish.

Leveling the Weld 1		Premium 3M™ Cubitron™ II Fibre Disc 987C
		Advanced 3M™ Fibre Disc 787C
Setting the Grain 2		Premium 3M™ Cubitron™ II Belt 947A
		Advanced 3M™ Belt 777F
Final Finishing: Choose Your Finish 3		Premium #3 Finish: Scotch-Brite™ Surface Conditioning Belt A CRS #4 Finish: Scotch-Brite™ Surface Conditioning Belt A MED #5–8 Finish: 3M™ Trizact™ Abrasive Belt 237AA / 217EA

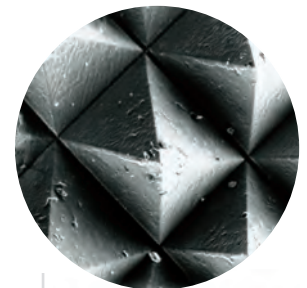


CUBITRON™ II

The precision-shaped grain found in 3M™ Cubitron™ II belts continuously fractures to form sharp points and edges.



Scotch-Brite™ non-woven synthetic fiber and abrasive mineral forms a web that is open, tough, conformable and long-lasting.



Trizact™

Trizact grain featuring microreplicated three-dimensional abrasive structures for the finest finishes.

2

Setting the Grain

Use these products to generate a directional scratch to prepare stainless steel for final finishing.

Recommended Starting Point



3M™ Cubitron™ II Cloth Belt 947A

120+

- ▶ 3M Precision-Shaped Grain slices through metals like a knife rather than gouging or plowing
- ▶ Removes material faster, with less pressure
- ▶ Grinding aid for less grinding friction and cooler cutting
- ▶ Optimized for low-medium pressure applications on stainless, mild steel and aluminum



Tech Tip: Attempt to stay as close as possible to the weld area to minimize final blending.

Alternative Selections



3M™ Cloth Belt 777F

P120

- ▶ Powered by a durable ceramic aluminum oxide blend that surpasses aluminum oxide abrasives in cut-rate
- ▶ Grinding aid reduces heat and increases performance, when used stainless steel



3M™ Flap Wheel 747D

80 3" x 1" x 1/4"

- ▶ Contains 3M™ Ceramic Aluminum Oxide blend abrasive grain
- ▶ Constructed on a resin-bonded X-wt., durable cloth backing
- ▶ Provides a uniform finish
- ▶ Features a grinding aid for cooler grinding of stainless steel

Troubleshooting Guide for Stainless Steel Repair

Problem	Solution
Heat or Warpage	<ul style="list-style-type: none"> ▶ Use coarser grade abrasive ▶ Reduce speed ▶ Use new abrasive ▶ Use harder disc pad
Edge Cutting	<ul style="list-style-type: none"> ▶ Use softer disc pad ▶ Reduce angle of grinder
Disc Scratches Show Through	<ul style="list-style-type: none"> ▶ Use finer grade leveling disc ▶ Increase speed
Chatter	<ul style="list-style-type: none"> ▶ Reduce speed and/or pressure
Flap Wheel Bounce	<ul style="list-style-type: none"> ▶ Reduce speed and/or pressure ▶ Use smaller wheel
Multi-finishing Wheel Bounce	<ul style="list-style-type: none"> ▶ Reduce speed ▶ Dress wheel to round
Smearing	<ul style="list-style-type: none"> ▶ Reduce speed ▶ Clean or replace contaminated product
Tool Stalling	<ul style="list-style-type: none"> ▶ Check for proper air supply at tool ▶ Increase torque and/or HP of tool
Streaking on Final Finish	<ul style="list-style-type: none"> ▶ Use 3M™ Twist-Lok™ Pad Holder 961