

# 3M

# Diamond Lapping Film

## Product Information Sheet

1. **3M I.D. Number:** 621X, 631X, 641X, 651X, 661X  
(658X PSA, 668X PSA)

2. **Mineral:** Industrial grade diamonds

<b>Grade (micron)</b>	<b>FEPA or JIS</b>	<b>*Size range (micron)</b>	<b>Color</b>	<b>Coating Thickness (microns)</b>
0.1	n/a	*0 - 1/2	green	6 - 9
0.5	JIS 10,000	*0 - 1	white	
1	JIS 8000	0 - 2	lavender	
1.5	JIS 7000	1 - 2	lt. green	
3	JIS 4000	2 - 5	pink	
6	JIS 2000	4 - 8	brown	
9	JIS 1200	6 - 12	blue	
15	JIS 800	10 - 12	orange	
20	JIS 600	15 - 25	burgundy	
30	JIS 400	20 - 40	green	

\*Sedimentation grading - different measurement methods may yield different range

3. **Backing:** polyester film - nominal 0.5 mil, 1 mil, 1.5 mil, 2 mil, 3 mil  
- actual 0.56 mil, 0.92 mil, 1.46 mil, 1.97 mil, 2.97 mil ( $\pm$  0.05)  
Ultimate tensile strength - 26,500 psi (typical)

4. **Bond:** resin - medium hardness (Knoop approx. 16)

5. **Available Forms:** rolls, sheets and discs

6. **Identification:** Each shipment will be identified by its product name, lot number and size.

7. **Recommended Storage Conditions:** Temp. 50-100 °F/relative humidity 30-70%  
(There is no performance degradation with time.  
It is recommended that product be used within 24  
months of purchase.)

8. **Applications:** Ceramic, glass, stone, carbide, composites, exotic alloys and other hard to grind materials.

**3M Suprabrasives and Microfinishing  
Systems Division**

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Effective Date: