3M™ Abrasives for Right Angle Tools
Field Guide

Featuring the new ADVANCED SERIES
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 designed 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 Grain and helps minimize your abrasive spend.
Key Application: Beveling

Lead with:

**Depressed Center Grinding Wheels**
For heavy grinding and aggressive applications when abrasive life is critical.

**Flap Discs**
Not as fast as fibre discs, but more user-friendly. Delivers a finer finish, with less chance of gouging.

**Fibre Discs**
The fastest way to achieve a bevel. Use 982C or 782C for carbon steel, 987C or 787C for stainless steel and other heat sensitive metals.

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**PREMIUM SERIES**

![3M™ Cubitron™ II Depressed Center Grinding Wheels](image1)

![3M™ Cubitron™ II Flap Discs](image2)

![3M™ Cubitron™ II Fibre Discs 982C/987C](image3)

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**ADVANCED SERIES**

![3M™ Silver Depressed Center Grinding Wheels](image4)

![3M™ Flap Discs 769F](image5)

![3M™ Fibre Discs 782C/787C](image6)

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**VALUE-PRICED PERFORMANCE**

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**TOP PERFORMANCE**

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Key Application:
Heavy Deburring, Slag Removal

Lead with:

Depressed Center Grinding Wheels
For heavy-duty jobs and large burrs that will shred most coated abrasive products.

Flap Discs
When removing an occasional large burr, flap discs will handle the job, without the necessity of changing discs.

Fibre Discs
Fastest cutting on smoother surfaces.

PREMIUM SERIES

3M™ Cubitron™ II Depressed Center Grinding Wheels
3M™ Cubitron™ II Flap Discs
3M™ Cubitron™ II Fibre Discs 982C/987C

TOP PERFORMANCE

ADVANCED SERIES

3M™ Silver Depressed Center Grinding Wheels
3M™ Flap Discs 769F
3M™ Fibre Discs 782C/787C

VALUE-PRICED PERFORMANCE
Key Application:
Weld Prep

Lead with:

**Clean & Strip Discs**
Remove epoxy, protective paint, mill scale, oils, rust, oxide coatings and primers/paints to clean and prepare the surface for welding.

**Flap Discs**
For more aggressive rust, paint and scale removal, or when material removal/dimensioning is necessary.

**Light Grinding & Blending Discs**
For light-duty scale removal and surface prep where a finer finish is desired.

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**PREMIUM SERIES**

Scotch-Brite™ Clean & Strip XT Pro Extra Cut Discs

3M™ Cubitron™ II Flap Discs

Scotch-Brite™ Light Grinding & Blending Discs

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**ADVANCED SERIES**

3M™ Flap Discs 769F

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**TIP 1:**
Scotch-Brite™ Light Grinding and Blending Discs achieve a high cut-rate in mild-steel applications, to effectively blend and refine a grade 36 scratch or finer.
Key Application: Back Gouging

Lead with:
Cut & Grind Wheels
Fast, smooth cutting, with less chatter on back gouging and root pass grinding. Very long life.

PREMIUM SERIES

FIELD GUIDE TECH TIPS

TIP 2:
Need a fibre disc for carbon steel? Use 3M™ Cubitron™ II Fibre Discs 982C or 3M™ Fibre Discs 782C. For stainless steel, try 3M™ Cubitron™ II Fibre Discs 987C or 3M™ Fibre Discs 787C.

TIP 3:
Flap Discs will often produce a finish equivalent to the next-finer grade of a fibre disc (i.e., a 60-grit flap disc will usually leave a finish similar to an 80-grit fibre disc) — saving you time and finishing steps!

TIP 4:
For even longer life, grind with less pressure when using Cubitron II products.
Which portfolio is best for your customer?
Choose 3M™ Cubitron™ II Abrasives for their legendary speed and long life, or Advanced Series discs and wheels for value-priced performance. Scotch-Brite™ Abrasives deliver consistent, reproducible results, making it easy to ensure quality finishes.

<table>
<thead>
<tr>
<th>What’s most important?</th>
<th>Choose this family of 3M Abrasives</th>
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<tbody>
<tr>
<td>Speed and long life – to improve productivity and lower overall production costs</td>
<td>Premium Series – 3M™ Cubitron™ II Abrasives</td>
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<tr>
<td>Consistency and ease of use – to improve surfaces without significantly changing the workpiece</td>
<td>Premium Series – Scotch-Brite™ Abrasives</td>
</tr>
<tr>
<td>Value-priced performance – to minimize abrasive spend while getting the job done efficiently</td>
<td>Advanced Series – 3M™ Abrasives</td>
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Which right angle product is best for your customer?
These general guidelines are a good starting point. Refer to the rest of the field guide for recommended products in specific applications.

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<td>Speed</td>
<td>Fibre Discs</td>
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<tr>
<td>Life</td>
<td>Depressed Center Grinding Wheels</td>
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<tr>
<td>Ease of Use</td>
<td>Flap Discs</td>
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TIP 6:
Cut-off wheels perform better the faster they run, so having a tool able to maintain speed is crucial.
WARNING: Do not exceed the specified maximum RPM.
Key Application: Finishing/Surface Prep

Lead with:

<table>
<thead>
<tr>
<th>Light Grinding &amp; Blending Discs</th>
<th>Flap Discs</th>
<th>Clean &amp; Strip Discs</th>
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<td>Ideal for refining grind marks and removing imperfections. Leaves a smooth, paintable finish.</td>
<td>For finish/scratch refinement, deburring and paint prep applications that require a more aggressive cut.</td>
<td>For cleaning and polishing stainless steel welds, removing weld burn discoloration, and cleaning/prepping mild steel prior to paint.</td>
</tr>
</tbody>
</table>

PREMIUM SERIES

- Scotch-Brite™ Light Grinding & Blending Discs
- 3M™ Cubitron™ II Flap Discs
- Scotch-Brite™ Clean & Strip XT Pro Discs

TOP PERFORMANCE

ADVANCED SERIES

VALUE-PRICED PERFORMANCE

TIP 5:

For highest productivity, choose 3M™ Cubitron™ II Flap Discs 967A for medium-duty or 969F for heavy-duty work. 3M™ Flap Discs 769F offer a value-priced alternative for great performance across a variety of medium- to heavy-duty applications.
Key Application: Blending

Lead with:

**Flap Discs**
Produce a fine finish, for blending and refining. User friendly. For an even finer finish, try Scotch-Brite™ Light Grinding & Blending Discs.

**Light Grinding & Blending Discs**
Ideal for refining grind marks and removing imperfections. Leaves a smooth, paintable finish.

**Fibre Discs**
Faster cutting, but may be trickier for inexperienced operators to control. Use grades 80+ and 120+ for blending.

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**PREMIUM SERIES**

- 3M™ Cubitron™ II Flap Discs
- Scotch-Brite™ Light Grinding & Blending Discs
- 3M™ Cubitron™ II Fibre Discs 82C/987C

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**ADVANCED SERIES**

- 3M™ Flap Discs 769F
- 3M™ Fibre Discs 782C/787C

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**VALUE-PRICED PERFORMANCE**

**TOP PERFORMANCE**

- Scotch-Brite™ Light Grinding & Blending Discs
- 3M™ Cubitron™ II Fibre Discs 82C/987C
Key Application: Weld Grinding

Lead with:

**Fibre Discs**
When speed is key. For longer life and/or higher-pressure applications, try Cubitron II Depressed Center Grinding Wheels.

**Flap Discs**
Not as fast as fibre discs, but more user-friendly. Delivers a finer finish, with less chance of gouging.

**Depressed Center Grinding Wheels**
For heavy-duty weld grinding and other heavy grinding operations. Very long lasting.

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**PREMIUM SERIES**

- 3M™ Cubitron™ II Fibre Discs 982C/987C
- 3M™ Cubitron™ II Flap Discs
- 3M™ Cubitron™ II Depressed Center Grinding Wheels

**ADVANCED SERIES**

- 3M™ Fibre Discs 782C/787C
- 3M™ Flap Discs 769F
- 3M™ Silver Depressed Center Grinding Wheels

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**TOP PERFORMANCE**

- 3M™ Fibre Discs 782C/787C
- 3M™ Flap Discs 769F
- 3M™ Silver Depressed Center Grinding Wheels

**VALUE-PRICED PERFORMANCE**

- 3M™ Fibre Discs 782C/787C
- 3M™ Flap Discs 769F
- 3M™ Silver Depressed Center Grinding Wheels
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