



THE FINISHING TOUCH

New Scotch-Brite™ Flap Brushes

Designed for a wide range of finishing to give you:
Consistent finishing
Outstanding life
Maximum productivity

3M



Scotch-Brite™ flap brushes are used to impart finishes on metal.

Artistic finishes are commonly found in stainless steel furniture, appliance, and sinks markets. Additionally, Scotch-Brite™ flap brushes are used on metals like copper, bronze and brass to apply high quality aesthetic finishes. Industrial equipment in the stainless-steel Food & Beverage, and Pharmaceutical markets. These functional finishes meet specific sanitary requirements used on stainless steel surfaces for process equipment.



Scotch-Brite™

Satin Finish flap brush

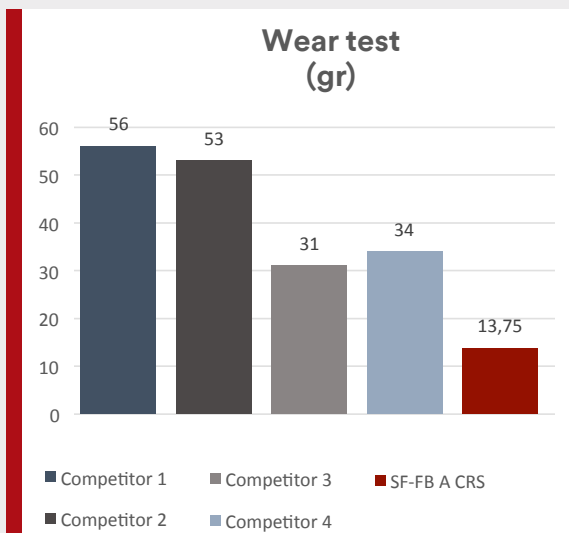
The new non-woven SF-FB is a high density abrasive material suitable for metal finishing and deburring applications. This new flap brush has outstanding wear resistance on irregular and sharp surfaces. Designed to apply or restore the original satin finish throughout the life of the brush.



Scotch-Brite™ Satin Finish flap brush creates or restores finish.



Larger Satin Finish flap brush for fixed or portable equipment used for small and medium sized workpieces.



Mineral Type			Brush Color	Grade
Aluminum Oxide			Gray	CRS
SAP ID	Diameter (mm)	Width (mm)	Center Hole (mm)	
7100146146	110	50	19	
7100146027	110	100	19	
7100146327	200	50	76	
SAP ID	Diameter (mm)	Width (mm)	Spindle (mm)	
7100144560	60	30	6	

Scotch-Brite™

Cut and Polish flap brush

A Cut and Polish flap brush is designed for finishing and blending stainless steel, and deburring metal surfaces. The durability and consistency features provide a premium product for the stainless steel industry.

Applications

- Deburring on a variety of substrates. Generally mounted on a bench motor.
- Light cleaning of surface residues or discoloration.
- Restore original satin finish.
- Coarser grades scratches refining.



Mineral Type			Brush Color	Grade
Aluminum Oxide			Brown	VFN, MED
SAP ID	Diameter (mm)	Width (mm)	Center Hole (mm)	
7000094880	100	50	19	
7100155222	110	100	19	
7100147922	200	20	76	
7100155225	200	50	76	
SAP ID	Diameter (mm)	Width (mm)	Spindle (mm)	
7100093982	50	25	6	
7100155223	60	30	6	
7100093979	75	45	6	
7100150669	100	50	6	

Scotch-Brite™

Clean & Finish flap brush

Clean & Finish flap brushes have been developed in different grades to allow you to produce the widest range of aesthetic finishes on different metals (such as stainless steel, bronze, copper, etc), with extraordinary high durability and consistent finish.

Applications

- All aesthetic finishing applications.
- Blending the original satin finish.
- Surface prep before bonding.



Mineral Type			Brush Color	Grade
Aluminum Oxide			Brown	VFN, FIN, MED
Silicon Carbide (S)			Gray	VFN, FIN
SAP ID	Diameter (mm)	Width (mm)	Center Hole (mm)	
7000091723	100	100	19	
7000091719	150	50	50	
7000091720	200	25	76	
7000035229	200	50	76	
SAP ID	Diameter (mm)	Width (mm)	Spindle (mm)	
7100093981	75	45	6	

Technical Information

Surface Speed Conversion

RPM at Arbor or Spindle	Surface Speed by wheel diameter (m/sec)					
	60	110	200	250	300	400
500	2	3	6	7	8	11
600	2	4	7	8	10	13
700	3	5	8	10	12	15
800	3	5	9	11	13	18
900	3	6	10	12	15	20
1000	4	6	11	14	16	22
1500	5	9	16	20	24	32
2000	7	12	22	27	32	43
2500	8	15	27	34	40	54
3000	10	18	32	40	48	64
3500	12	21	38	47	56	75
4000	13	24	43	54	64	86

Recommended Operating Speeds

Maximum operating speed: brushes must be used within specified maximum operating speeds (M.O.S).

Refer to the recommended operating speed chart.

Diameter of Brushes	m/min
Decorative finishing	150-900
Composites/Soft materials	350-800
Cleaning and conditioning	600-1500
Prepolishing	600-2100
Oxide removal	1300-1900
Deburring	1500-1900

Coolant and Grinding Aids

Although these are not required for most applications, most common industrial grinding lubricants, coolants, and/or compounds can be used with Scotch-Brite™ flap brushes if necessary.

Maximum Operating Speeds (RPM)

	Diameter (mm)					
	60	110	200	250	300	400
Satin Finish	9600	5700	2800	N/A	N/A	N/A
Cut and Polish	9000	5700	4000	2700	2000	1900
Clean&Finish	9000	5700	3200	2500	2000	1500

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