

**Scotch-Brite™**  
Flap Brushes



# The Finishing Touch



Now with  
longer life & even  
greater consistency

Designed to create a  
variety of high-value  
aesthetic finishes—faster  
& easier than ever before!

**3M**

Scotch-Brite™ Flap Brushes are used by manufacturers of hand tools, surgical equipment, stamped metal parts, transportation vehicles, builders hardware, plastic products, mouldings, other woodworking products, and much more.

Aerospace component manufacturers condition surfaces of blades, vanes, rotors, fasteners, nozzles, extrusions and airframe supports.

In maintenance and repair, Scotch-Brite flap brushes are used to clean and condition surfaces properly and efficiently.



**Scotch-Brite™ HS Blend & Finish Premium Flap Brushes** **NEW!**

3M's best-performing flap brush. Scotch-Brite Blend & Finish Premium brushes provide greater durability, longer life and exceptional finish, while running soft, smooth and smear free. Available in Type L (Lofty) versions allowing maximum conformability and consistency.

**Scotch-Brite™ Clean & Finish Premium Flap Brushes** **NEW!**

When sacrificing finish is not an option. Scotch-Brite Clean & Finish Premium brushes provide the ultimate finish consistency, conformability and smear resistance.

**high performance**

Mineral Type		Brush Color	Grade
Aluminum Oxide		Brown	CRS
		Brown	CRS Type L
		Gold	MED
		Gold	MED Type L
		Maroon	VFN
Diameter (inches)	Center Hole (inches)	Width (inches)	Density (inches)
4-16	2, 3, 5, 8, 10	1/2-24	3, 5, 7

Mineral Type		Brush Color	Grade
Aluminum Oxide		Maroon	VFN, MED
Silicon Carbide		Gray	MED
Diameter (inches)	Center Hole (inches)	Width (inches)	Density (inches)
4-16	2, 3, 5, 8, 10	1/2-24	3, 5, 7



**Regular**

**Type L (Lofty)**

**Applications**

- Blending finishes back into fabricated metal
- Deburring with flexibility
- Antique finishes on hardware and plumbing fixtures
- Highlighting

**Applications**

- All aesthetic finishing applications
- Contoured part finishing
- Satin finishing on extrusions
- Wood profile defuzzing

**To order:** State product name, density, mineral type, grade, diameter x width x center hole.

**Example:** Scotch-Brite™ Finishing Flap Brushes, 5A-medium, 8" x 1" x 3".

Mineral Grade Abbreviations					
Coarse CRS	Medium MED	Fine FIN	Very Fine VFN	Super Fine SFN	Ultra Fine ULF

**Ordering Information**



### Scotch-Brite™ Cut & Polish Flap Brushes

High-cutting flap brushes for demanding blending applications and light deburring.

### Scotch-Brite™ Clean & Finish and Combi Flap Brushes

High-value brushes with good performance for a variety of applications in metalworking and woodworking. Clean & Finish brushes provide solid performance in a broad range of grades and conformabilities. Combi brushes utilize some of the same webs in combination with 3M's high-performance coated abrasives to provide cutting and finishing action in one step.

good performance

Mineral Type	Brush Color	Grade	
Aluminum Oxide	Tan	VFN, MED	
Diameter (inches)	Center Hole (inches)	Width (inches)	Density (inches)
6-16	2, 3, 4, 5, 8, 10	3/4-32 (or up to 66 with steel core)	3, 5, 7

#### Applications

Deburring a variety of substrates. Generally mounted on a backstand or bench motor.

Light cleaning of surface residues or discoloration

Removing oxides for surface preparation

Graining and blending handling marks

Final mould sanding and defuzzing

#### Clean & Finish Flap Brushes

Mineral Type	Brush Color	Grade	
Aluminum Oxide	Maroon	VFN, FIN, MED, CRS	
Silicon Carbide	Gray	ULF, SFN, VFN, FIN, MED	
Diameter (inches)	Center Hole (inches)	Width (inches)	Density (inches)
6-16	2, 3, 5, 8, 10	3/4-32 (or up to 66 with steel core)	3, 5, 7

#### Combi Flap Brushes

Mineral Type	Brush Color	Sandpaper Grade
Aluminum Oxide	Maroon	60, 80, 120
Silicon Carbide	Gray	150, 180, 120
Diameter (inches)	Center Hole (inches)	Width (inches)
8	3	3/4-32

#### Applications

All aesthetic finishing applications

Smoothing wood fibers

Wood profile defuzzing

Sealer scuffing

## Technical Information

### Surface Speed Conversion

	Surface Speed by Wheel Diameter					
	Feet per Minute (SFPM)					
	6"	8"	10"	12"	14"	16"
500	785	1045	1310	1570	1820	2094
600	940	1255	1570	1885	2195	2513
700	1100	1465	1835	2200	2560	2932
800	1256	1675	2094	2513	2932	3351
900	1413	1885	2356	2827	3298	3770
1000	1570	2094	2618	3141	3665	4189
1100	1727	2304	2880	3455	4031	4608
1200	1884	2513	3142	3769	4398	5027
1300	2042	2723	3404	4084	4764	5445
1400	2199	2932	3666	4398	5131	5864
1500	2356	3142	3927	4712	5497	6283
1600	2513	3351	4189	5026	5864	6702
1700	2670	3560	4451	5340	6230	7121
1800	2827	3770	4713	5650	6597	7540
1900	2984	3979	4975	5969	6963	7959
2000	3141	4189	5236	6283	7330	8378
2100	3298	4398	5498	6497	7696	8796
2200	3455	4608	5760	6911	8063	9215
2300	3612	4817	6022	7225	8429	9634
2400	3770	5027	6284	7540	8796	10053
2500	3927	5236	6545	7854	9162	10472
2600	4084	5445	6807	8168	9529	10891
2700	4241	5655	7069	8482	9895	11310
2800	4398	5864	7331	8796	10262	11729
2900	4555	6074	7592	9110	10629	12148
3000	4712	6283	7854	9425	10996	12566
3200	5026	6702	8378	10053	11729	13404
3400	5340	7121	8901	10681	12462	14242
3600	5654	7539	9425	11309	13193	15080
3800	5969	7958	9948	11938	13927	15917
4000	6283	8377	10472	12566	14661	16755

### Recommended Operating Speeds

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

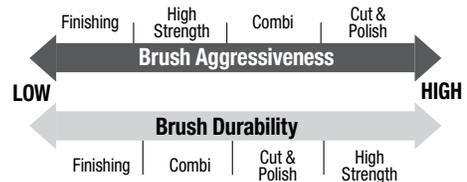
Refer to the recommended operating speed chart for specific recommendations, which usually are less than the M.O.S.

Diameter of Brushes	SFPM
Decorative finishing*	500–3000
Composites/Soft materials	1200–2700
Cleaning and conditioning	2000–5000
Prepolishing	2000–7000
Oxide removal	4500–6500
Deburring	5000–6500
Wood sanding	500–2500

\* Finishing Flap Brushes should not be run over 3500 SFPM

### Maximum Operating Speeds (RPM)

	Wheel Diameter					
	6"	8"	10"	12"	14"	16"
Cut & Polish Flap Brush	4000	4000	3200	2700	2000	1900
Finishing Flap Brush	3400	3200	2500	2500	2000	1500
High Strength Flap Brush	3400	3200	2500	2500	2000	1500
Combi Flap Brush	3400	3200	2500	2500	2000	1500



### Hardware Required

Flanges are offered for adapting Scotch-Brite™ Flap Brushes to standard production equipment.

Typical flanges include #349 for 2" CH brushes and #356 for 3", 4", 5", 8", 10" CH brushes.

### Coolants 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.

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