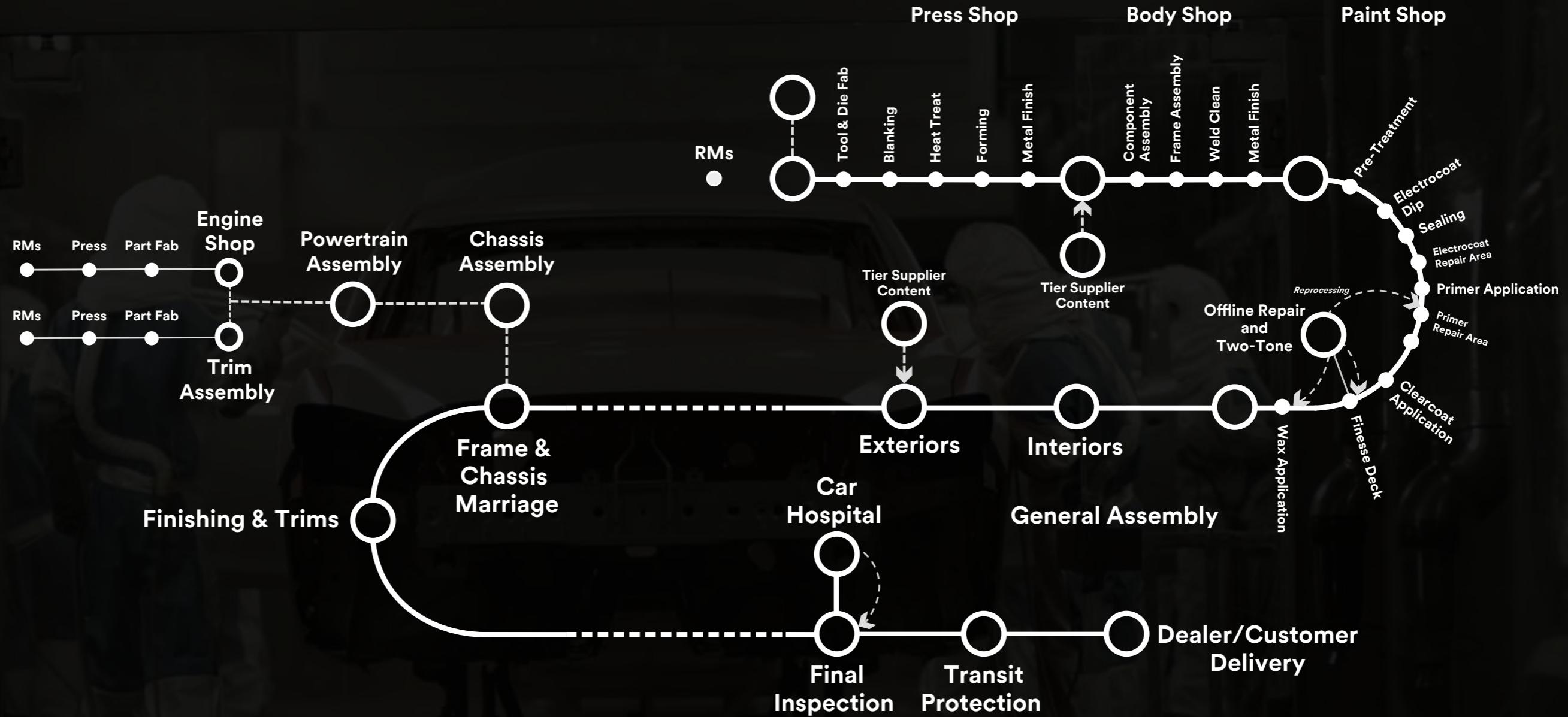


**3M** Science.  
Applied to Life.™

# Automotive Manufacturing Solutions Field Guide →



# Process Map



The 3M™ Automotive Manufacturing Solutions Field Guide details the materials and tools we make for the world's most competitive production lines. Solutions engineered to pull the biggest opportunities out of the smallest details. Helping to improve efficiency, optimize costs, increase quality and drive output each step of the way.

Every car, van or truck built to perfection – one step, one solution at a time.

This is advantage in the making.

As you read this guide, we list either the solutions recommended for each process step or, in the case where only one product is needed, a selection of that product type with the recommended order to try from left to right.

For more in-depth knowledge and answers to questions about the contents of this Field Guide, reach out to your 3M sales professional who will be happy to assist.



# Press Shop ➔

## Introduction

The Press Shop marks the beginning of the process for most (but not all) plants. Metal sheets are supplied in large rolls called coils and then pressed into shape to form both internal and external panels. Some manufacturers centralize this part of the process at standalone facilities and, with an increase in the use of exotic substrates, some also outsource to specialist Tier suppliers. In some geographies, this area is known as **Stamping**.

- Panel Highlighting\*
- Panel Repair\*
- Die Maintenance



\* These applications can be found in either Press Shop or Body Shop

Application	Objective
<b>Panel Highlighting</b>	To make it easier to locate and identify defects. Objective is not to remove material.
<b>Featured Products</b>	 <b>3M Xtract™ Cubitron™ II Net Disc 710W</b>  <b>3M™ Trizact™ Hookit™ Film Disc 268XA</b>  <b>3M™ Hookit™ Disc Hand Pad</b>
<b>Panel Repair</b>	To remove defects prior to panel passing down process. Defect size determines if 1, 2 or 3 steps are needed.
<b>Featured Products</b>	 <b>3M™ Cubitron™ II Fibre Disc 982CX</b>  <b>3M™ Xtract™ Cubitron™ II Film Disc 775L</b>  <b>3M™ Xtract™ Random Orbital Sander</b>  <b>Portable Dust Extraction Unit</b>
<b>Die Maintenance</b>	Panel defects can often be traced back to cracks in the die. These are often repaired by welding.
<b>Featured Products</b>	 <b>3M™ Cubitron™ II Roloc™ Disc 984F</b>  <b>Scotch-Brite™ Roloc™ Surface Conditioning</b>  <b>3M™ Disc Sander</b>

## Manual Process

Using light pressure, move the abrasive disc across the panel surface to highlight and denib small imperfections.



### 3M Xtract™ Cubitron™ II Net Disc 710W

Stamping operations frequently leave imperfections on car panels. 3M Xtract™ products are used to sand lightly on white metal, causing high spots to shine a little brighter. The open mesh works well because the oily surface does not load.

- Used with 3M™ Hookit™ Disc Hand Pads



### Scotch-Brite™ Cut and Polish Unitized Block

Heavy duty for aggressive blending and finishing.

- 5A Fine



### 3M™ Flexible Diamond Hand Lap 6200J

Ideal for finishing applications that require aggressive sanding. Flexible enough for contoured surfaces.

- Alternative option: 3M™ abrasive grade 220 or finer

## Other Options



3M™ Trizact™ Hookit™ Film Disc 268XA



3M™ Hookit™ Disc Hand Pad



3M™ Interface Pad



3M™ Hookit™ Diamond Microfinishing Film Disc 675L



3M™ Flexible Diamond QRS Cloth Disc 6002J



3M™ Brushlon™ 320B

## Step 1: Body Filing

Automotive body files are used in a straight motion to remove or shave down small imperfections from both steel and aluminum panels.



- Keep the repair size as small as possible
- Deep file scratches will be difficult to remove at step 2
- Do not file more than necessary and take care on detail lines
- We recommend a crossed tooth bow file

## Step 2: Blending (for steel end at this step)

Once the imperfections have been filed, any file marks that are left should be removed and left below an 8µm RZ rating, to prevent costly rework and repairs.



### 3M Xtract™ Cubitron™ II Film Disc 775L

These discs are recommended to remove the file marks and provide the correct surface finish.



### 3M Xtract™ Random Orbital Sander

Maximum orbit used in this area should be 3/16" (5mm). Anything larger will be too aggressive and have increased vibration levels. Note: you may still find a rotary step being used prior to this Random Orbital step. In many cases, we can now eliminate the orbital step, but in the event you do still have the need, we recommend the 982CX Fibre Disc.

## Step 3: Burr Removal & Refining

After the file marks have been removed, burrs may appear from the sanding marks. When the substrate is aluminum, this is a vital process step to help prevent corrosion.



### Scotch-Brite™ Hookit™ 7447 Pro Disc

Instead of using the hand pad form, using the disc on machine ensures that the necessary RZ finish is achieved and preparation marks are not visible after coating procedures.



7447 Pro on machine



7447 Pro on hand

## Press Shop Die Maintenance

## Press Shop Die Maintenance

### Step 1: Grind the defect on molds

Panel defects can be often traced back to cracks in the die. These are often repaired by welding.



**3M™ Cubitron™ II Roloc™ Durable Edge Disc 947A**

For flat areas



**3M™ Roloc™ Disc 361F**

For curved surfaces



**Tools: 3M™ Disc Sanders**

For small areas, attach an adapter to these tools



**Accessories: 3M™ Roloc™ TR Disc Pads**

### Step 2: Polish the defect



**Scotch-Brite™ Roloc™ Surface Conditioning Disc**

Remove scratches



**Scotch-Brite™ Roloc™ Surface Conditioning Disc**

Finer finish



**Scotch-Brite™ Roloc™ Unitized Deburr and Finish Pro Wheel**

For final finish



**Scotch-Brite™ Roloc™ Surface Conditioning Disc**

For final finish



**Scotch-Brite™ Hand Pad 7448PRO**

For curved shapes

### Optional Step: Remove burned oil



**Scotch-Brite™ Roloc™ Bristle Disc**



**Scotch-Brite™ Roloc™ Clean and Strip XT Pro Disc**

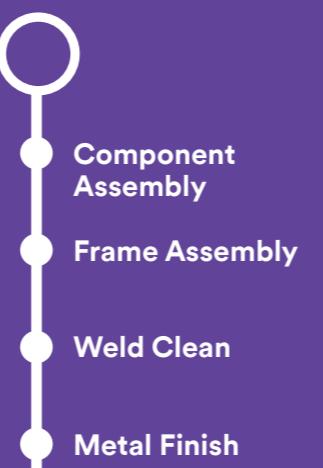


# Body Shop

## Introduction

Often referred to as the Body-in-White (BiW), at this stage, all pressed panels are brought together to form the body of the vehicle. A complex mix of welding, fastening and bonding applications leads to the need to clean and repair the body before it is ready to be passed to the Paint Shop.

- Brazed Weld Removal
- Flange Reduction
- Spot Weld Cleaning
- Laser Weld Clean
- Weld Splatter Removal



Application	Objective
<b>Flange Reduction</b>	To correct misalignment between two attached panels.
<b>Featured Products</b>	   
<b>Brazed Weld Finishing</b>	To remove excess braze and provide a smooth, paintable surface.
<b>Featured Products</b>	   
<b>Spot Weld Cleaning</b>	To refine finish and avoid issues down process.
<b>Featured Products</b>	   
<b>Laser Weld Clean</b>	To remove weld residue and avoid contamination issue down process. Many OEMs will paint directly onto the weld.
<b>Weld Spatter Removal</b>	To remove weld residue and avoid contamination issue down process.
<b>Featured Products</b>	 

## Body Shop Flange Reduction

### Procedure

The flange is created when parts, such as panels, doors, hoods, etc. are joined together, but turn out to be misaligned. Today, general process improvements mean this application is not as common, and so is less of an issue.

<b>3M™ Fibre Discs</b>	 Steel: 3M™ Cubitron™ II Fibre Disc 982CX Pro      Aluminum: 3M™ Fibre Disc 787C
<b>3M™ Roloc™ Discs</b>	 3M™ Cubitron™ II Roloc™ Disc 947A
<b>3M™ Roloc™ Quick Release System</b>	 3M™ Disc Sanders      3M™ Roloc™ TR Disc Pads

## Body Shop Brazed Weld Finishing

### Application

AOEMs are designing their vehicles with a clean roof line resulting in the need for a laser braze weld along the length of the roof ditches.



- Laser brazing is a newer development in the auto industry, in which body panels are brazed together with silicon bronze
- The resulting brazed surface is then blended to create a more uniform surface segment
- The removal and finishing of excess metal make the brazed parts as clean and smooth as the attached surfaces

### Advantages of brazing over welding

- Lower total cost
- Smooth finish of weld
- Produces a paintable surface
- Line instead of spot joints
- Avoid degrading the zinc coating for better corrosion protection
- Less noise
- Better aesthetics



### Scotch-Brite™ Laser Braze Finishing Wheel, LB-UW

Designed for use with active force control systems; for smoother brazed joints, where less removal is needed.



### Scotch-Brite™ EXL PRO Unitized Wheel

Designed for higher pressure robotic and hand held leveling, finishing and cleaning of continuous brazed welds on roof/body joints (with more variability/deeper pits and ripples).



### Scotch-Brite™ Rapid Cut Unitized Wheel

Deburr and smooths the edges of all types of metal at top speed, even where heat sensitivity is an issue.



### 3M™ Die Grinders

Excellent for big jobs such as weld or stock removal; reduces vibration and provides a more secure grip.

For more in-depth knowledge and answers to questions about process automation needs, reach out to your 3M sales professional or connect with one of our automation experts: [3m.com/robotics](http://3m.com/robotics)

## Body Shop Brazed Weld Finishing

To achieve optimum results from a robotic brazed weld finishing line, it is important to balance the right levels of key process parameters such as wheel speed, force, robot arm speed and wheel rotation direction.

### Automated Process: Performance Factors



#### Wheel Speed

- More speed = more cut
- If wheel is not cutting enough to finish roof ditch, the RPM can be increased within the Max RPM of the product
- High speed can cause wheel degradation and possible deposition on part

#### Force

- Force must be optimized to achieve desired finish, cut rate and wheel life
- Ideally, run the least force possible to achieve the desired results
- More force = more cut but increases wheel wear and risk of wheel flex which can inhibit proper ditch tracking

#### Robot Arm Traverse Speed

- More arm speed = less cut
- As robot arm speed increases, cut rate will decrease as wheel will have less time in contact with the roof ditch

#### Rotation of Wheel

- Climb Cut (wheel rotation with feed direction) will result in longer scratch, less cut, less wheel wear
- Conventional Cut (wheel rotation against feed direction) will result in shorter scratch, more cut, more wheel wear
- Ensure same cut direction is leveraged on both sides of vehicle body

### Suggested Performance Settings

Force target when customer has a finer braze and is focused on finish quality	Force target when customer has a rougher braze and is focused on productivity	Wheel Speed Target	Wheel Speed Range	Traverse Speed Target/Range
4-6 lbf (18-25 N) recommend LB-UW	6-9 lbf (25 - 40 N) recommend EXL PRO	6,200 SFPM/ 31.5 m/s (3000 RPM for an 8" wheel)	4,800-8,000 SFPM/m/s	200 mm/s target (150 - 250 mm/s range), dependent on the cycle time requirement of the system

lbf=pounds of force

SFPM=Surface feet per minute

mm=millimeter

N=Newtons (units of measure smaller than pound)

RPM=Rotation per minute

## Body Shop Spot Weld Cleaning/Deburring

### Manual Application



### 3M™ Roloc™ Discs

#### 3M™ Roloc™ Discs



3M™ Cubitron™ II Roloc™ Durable Edge Disc 947A



Scotch-Brite™ Roloc™ Surface Conditioning Disc, SC-DR

### 3M™ Belts



3M™ Cubitron™ II Cloth Belt 784F



Scotch-Brite™ Durable Flex Low Stretch Belt

### 3M™ Power Tools



3M™ Disc Sander



3M™ File Belt Sander

Disclaimer: Roof ditch always depends on thickness of wheel, shape of roof, curves and angles; all influence life of consumable.

## Body Shop Weld Spatter Removal



Weld spatter often consists of molten metal or non-metallic materials, such as oil, that are scattered, splashed or burned on during the welding process and can take the form of soot.

### Scotch-Brite™ Radial Bristle Brush

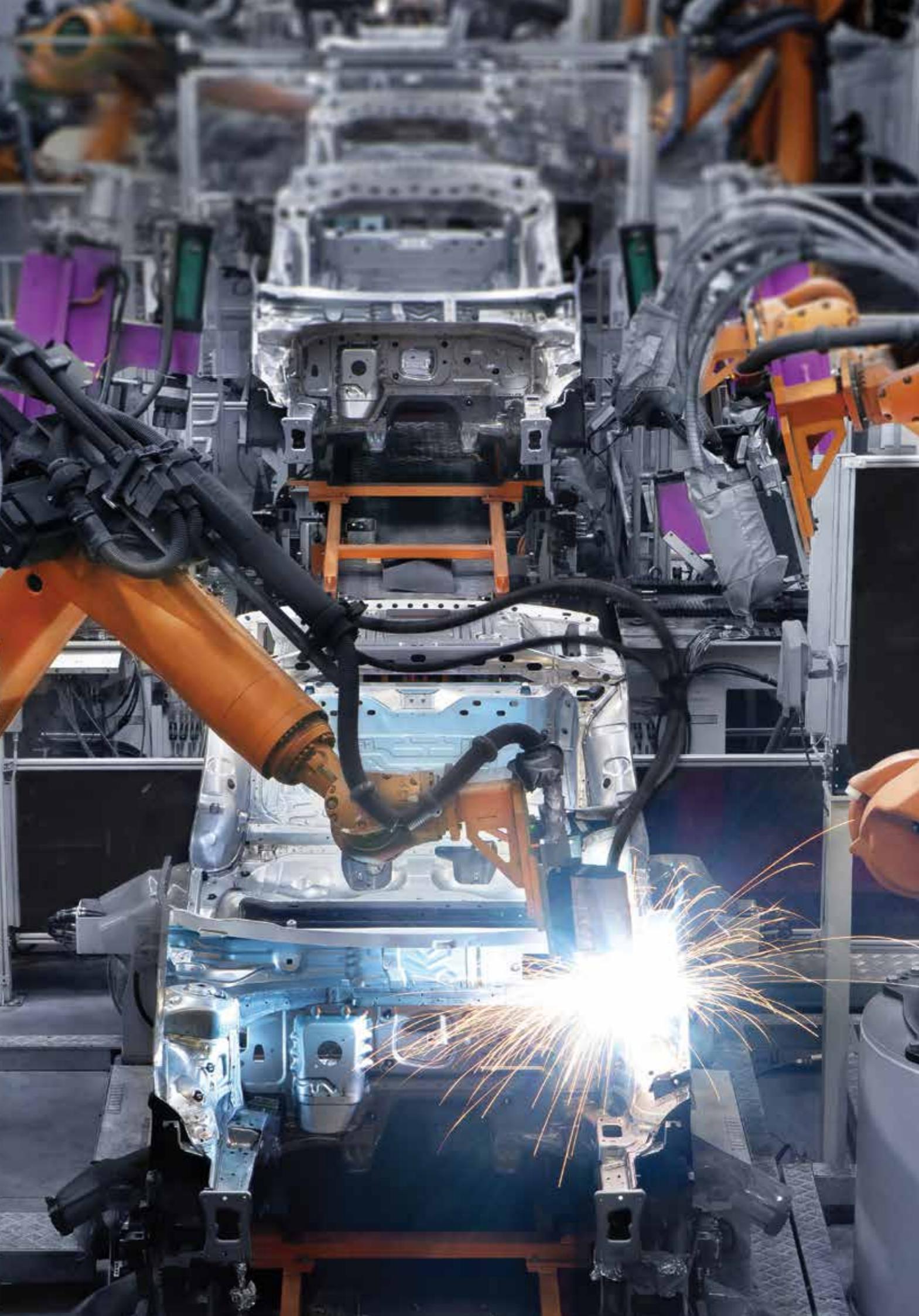
Quickly removes burrs and sharp edges in end-of-arm tooling operations, delivering consistent performance through the full life of the abrasive.

- High finish quality throughout the life of the brush
- Conformability creates uniform finishes on complex-shaped parts, protrusions, detail grooves, patterns and other hard-to-reach areas
- Minimal pressure and cool cleaning
- Configurable to desired width



These small bits of hot material may fly and fall on the workbench or on the floor, while others may stick to the base material or any surrounding metallic material.

For more in-depth knowledge and answers to questions about process automation needs, reach out to your 3M sales professional or connect with one of our automation experts: [3m.com/robotics](http://3m.com/robotics)



# Paint Shop



## Introduction

In this part of the process, the vehicle body is given its corrosion protection layer known as the electrocoat. It is sealed to prevent water leaks, painted the customer's choice of color and then a clearcoat is applied to give a high-gloss appearance that provides additional protection from UV, stone chips and bird lime.

- Electrocoat Preparation
- Primer Preparation
- Clearcoat Repair
- Offline Repair
- Contrast Roof



Application	Objective
<b>Electrocoat Preparation and Primer Preparation</b>	To remove inclusions and runs prior to the application of the next paint layer. Note: Some OEMs also perform Highlighting in this area.
<b>Featured Products</b>	 3M Xtract™ Cubitron™ II Net Disc 710W
<b>Basecoat and Clearcoat Application</b>	To apply paint in areas that are not covered by an automated process.
<b>Featured Products</b>	 3M™ Performance Spray Gun
<b>Clearcoat Repair</b>	To remove inclusions in the final paint layer, leaving a defect-free, high-gloss finish.
<b>Featured Products</b>	 3M™ Finesse-it™ Trizact™ 468LA Film Discs

## Paint Shop Electrocoat/Primer Preparation



### Electrocoat Preparation

Once the vehicle has been rinsed, the vehicle is:

- Dipped in the e-coat dip tank
- Moved into curing oven to be baked
- Sealed
- Sanded on the E-coat sanding deck
- Bonded (high-temp tape)



### Primer Preparation

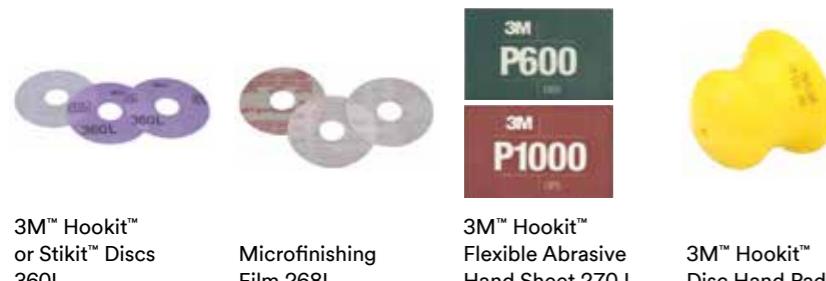
After the vehicle is e-coated, it moves further along the production line where:

- Primer is applied to the surface of the vehicle
- Moves into curing oven to be baked
- Sanded on the primer sanding deck

Note: Some plants may not perform primer preparation because they have adopted a primer-less system or a '3-Wet' system.

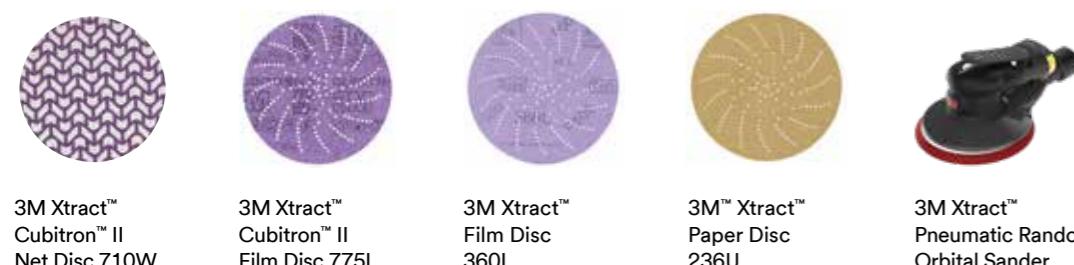
### Hand/Damp Sanding (preferred)

This method requires no compressed air, removes less coatings and will not break through to bare metal (causing corrosion). It can remove most defects in the e-coat and primer surface, including runs, dirt, inclusions, etc.



### Machine/Random Orbital Sanding (for large areas)

Dust extraction discs can be used to reduce airborne dust and the high risk of contamination on the rest of the bodies as they travel to the base coat area.



## Paint Shop Electrocoat/Primer Sanding

As more plants look to automate their electrocoat and primer sanding operations, one key consideration critical to success is force control.

### Active Force Control (preferred)

Active force control systems automatically compensate for tool orientation and thereby the impact of gravity, to ensure that constant normal applied force is achieved during abrading.

This technology can minimize the more complex and time-consuming programming which can be required to leverage passive force control systems on parts with complex geometry. In addition, active systems are typically more accurate than passive systems due to their continuous compensation capability.

- Provides and maintains compliance level based on feedback of various parameters
- Offers more accuracy of applied force than passive

### Passive Force Control

Passive force control systems do not automatically compensate for tool orientation and the impact that has on actual applied normal force.

One can use various tools such as programmable regulators to enable manual programming to compensate for tool orientation, but those systems do require time and expertise for the programming and will not typically be as accurate as active force control systems. Geometrical complexity of the part being abraded will be a critical factor in determining the type of force control technology chosen.

- Provides force based on level set in system but does not adapt to feedback
- Typically a lower-priced solution than active



For more in-depth knowledge and answers to questions about process automation needs, reach out to your 3M sales professional or connect with one of our automation experts: [3m.com/robotics](http://3m.com/robotics)

## Paint Shop Basecoat/Clearcoat Application

### Basecoat



Basecoat contains the visual properties of color and effects and is usually the coat referred to as "paint."

### Clearcoat



Clearcoat is sprayed on top of a colored basecoat and is a glossy and transparent coating that forms the final interface with the environment.

### Manual Application



#### 3M™ Performance Spray Gun

Capable of spraying a wide range of coatings from either a pressure-fed source or attached gravity cup.

Impact-resistant composite body makes it one of the lightest spray guns available, yet it is durable enough for demanding industrial and automotive conditions.



#### 3M™ PPS™ Series 2.0 System

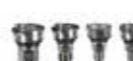
World's first disposable paint cup system for cleaner, easier, faster painting:



3M™ PPS™ Series  
2.0 Lid and Liner Kits



3M™ PPS™ Series  
2.0 Cups



3M™ PPS™ Series  
2.0 Adapters



3M™ PPS™ Series  
2.0 Accessories



#### 3M™ Dirt Trap Protection Material

Protects and brightens paint booth walls and floors. Non-woven construction traps dust and overspray, and its bright white color creates better visibility. Low-tack adhesive backing keeps it secure, smooth and wrinkle free.



#### 3M™ Booth Coating

Protects paint booth walls and lights from paint overspray. Dries to a clear film across fittings, walls and windows. The non-tacky formula won't discolor from dust or dirt and removes cleanly with water.

## Paint Shop Clearcoat Repair

### Step 1: Machine Sanding



- Level/remove the defect using a Mini Orbital Sander and film disc
- Spray the disc with water to prevent the abrasive from loading during sanding
- Sand the defect for 1-3 seconds, depending on its size
- Wipe the area clean



#### 3M™ Finesse-it™ Mini-Random Orbital Nib Sander

Small, easy-to-use sander for repairing small defects in paint and clearcoat surfaces



#### 3M™ Finesse-it™ Trizact™ 464LA, 466LA & 468LA Film Discs

Ideal for the 3M two-step paint defect repair process for automotive finishes



#### Scotch-Brite™ High Performance Cloth

Microfiber cleaning cloth that effectively lifts dirt and grease instead of rolling over it

### Step 2: Polishing



- Apply a small drop of polish on the sanded area
- Spread the polish evenly over the spot using the buffering pad, without running the buffer
- Polish for 8-12 seconds
- Wipe the area clean



#### 3M™ Finesse-it™ Polish Premium Series 300

Fastest one-step polish process on today's premium 2k clearcoats; haze-free, high-gloss finish



#### 3M™ Finesse-it™ Random Orbital Buffer

Use with 3M™ Finesse-it™ Polishes and Foam Buffing Pads for a uniform finish on today's paint finishes



#### 3M™ Finesse-it™ Buffing Pads

Provides soft, smooth surface for applying 3M™ Finesse-it™ polishes

# Paint Shop Clearcoat (Defect) Repair

# Paint Shop

Today, the vast majority of cars require clearcoat defect repair. Operators work in close quarters to identify, sand and polish 2-30 imperfections in the clearcoat as the vehicle moves down the line.

While some hard-to-reach areas or certain defect types must be done manually offline, many other defects like dirt, fibre, pops and scratches on flat, accessible locations can be automated.

## Automated Process



Defects repaired by robots will be completed as competently and efficiently as they are with workers, with cycle times equal to or faster than current operations.

- Defects on or near vehicle feature lines can be more challenging due to specific limitations of the robot and/or the vision system
- Some defects may need to be repaired by an operator

## 3M™ Finesse-it™ Robotic Paint Repair System



## Consumables



## System Integration



Inovision



ASIS

For more in-depth knowledge and answers to questions about process automation needs, reach out to your 3M sales professional or connect with one of our automation experts: [3m.com/robotics](http://3m.com/robotics)

Application	Objective
<b>Offline Repair</b>	To remove defects that are too large to be taken out during the online process.
<b>Featured Products</b>	 3M Xtract™ Cubitron™ II Net Disc 710W  3M Xtract™ Cubitron™ II Film Disc 775L  3M™ Finesse-it™ Trizact™ 468LA Film Discs  3M™ Finesse-it™ Polish Premium Series 300
<b>Two-Tone</b>	Increasingly common process where part of the vehicle is prepared for an alternative paint color.
<b>Featured Products</b>	 Scotch-Brite™ Hand Pad 7447 Pro  3M Xtract™ Cubitron™ II Film Disc 775L  Scotch® High Performance Masking Tape 2693  Scotch® Fine Line 4737
<b>End-of-Line Repair</b>	Last opportunity to repair defects before the car is subject to warranty.
<b>Featured Products</b>	 3M™ Performance Spray Gun  3M™ PPS™ Series 2.0 Lid and Liner Kits  3M Xtract™ Cubitron™ II Net Disc 710W  3M™ Perfect-it™ EX AC Rubbing Compound

# Paint Shop Two-Tone

**Two-Tone or “Contrast Roof”** Describes an application where the roof and body of the car are painted different colors.

Step 1: Light scuffing			
<b>Hand Sanding</b>		Scotch-Brite™ Hand Pad 7447 Pro	3M™ Hookit™ Flexible Foam Abrasive Disc*
			
<b>Machine Sanding</b>		3M Xtract™ Cubitron™ II Net Disc 710W	3M Xtract™ Cubitron™ II Film Disc 775L
			
<b>3M™ Hookit™ Disc Hand Pad</b>		3M™ Hookit™ Disc Hand Pad	3M™ Xtract™ Pneumatic Random Orbital Sander
			

## Step 2: Masking



### 3M™ High Performance Masking Tapes

For bake temperatures up to 300°F (149°C) or for multiple bake cycles.



Scotch® High Performance Masking Tape 2693



Scotch® High Performance Masking Tape 2380



Scotch® High Performance Masking Tape 501+



### Scotch® Fine Line Tapes

Scotch® Fine Line series masking tapes provide sharp paint lines, minimizing rework associated with paint bleed or poor paint line definition.



Scotch® Fine Line 4737



Scotch® Fine Line 4735



Scotch® Fine Line 218



### 3M™ Paper and Masking Film



3M™ High Temperature Paint Masking Film 7300



Scotch® Steel Gray Masking Paper

## Small Medium Area Repair Technology (SMART)



### Surface Preparation

- Sand out the defect starting with the finest grade possible
- Sand around the repair area
- Enlarge the area further with finishing disc

### Masking

- Cover the surrounding area to protect from overspray but leave the repair area large enough to avoid creating sharp paint lines

### Primer Application

- Apply the primer following paint company's recommendations
- Overspray must be kept to a minimum to keep the repair area as small as possible

### Primer Sanding

- Sand the primer using an abrasive disc or flexible abrasive sheet

### Paint Application

- Apply the paint following paint company's recommendations
- Use midi or mini PPS system depending on size of repair

### Defect Touch-up

- Level/remove the defect using a Mini Orbital Sander and film disc
- Spray the disc with water to prevent the abrasive from loading during sanding
- Sand the defect for 1-3 seconds, depending on its size
- Wipe the area clean

### Paint Rectification and Finish

The painted area should now be polished. A rotary polishing step followed by a Random Orbital De-Hologram step is commonly used here.

# Paint Shop Offline Repair

## Paint Shop End-of-Line Repair\*

### Manual Application

There can be a large variety of repairs made at the end of the line, also called "Car Hospital."



#### 3M™ Performance Spray Gun

Capable of spraying a wide range of coatings from either a pressure-fed source or attached gravity cup.

Impact-resistant composite body makes it one of the lightest spray guns available, yet it is durable enough for demanding industrial and automotive conditions.

#### 3M™ PPS™ Series 2.0 System

World's first disposable paint cup system for cleaner, easier, faster painting:



3M™ PPS™ Series  
2.0 Lid and Liner Kits



3M™ PPS™ Series  
2.0 Cups



3M™ PPS™ Series  
2.0 Adapters



3M™ PPS™ Series  
2.0 Accessories

#### 3M™ Masking Solutions

Full systems for the finest finishes, as well as controlling dust and overspray:



3M™ Scotchblok™  
Masking  
Paper



3M™ Clear Masking  
Film\* (Purple  
Premium Plus)



3M™ Performance  
Industrial Masking  
Tape 301+

## Paint Shop End of Line Repair

### 3M Xtract™ Clean Sanding Solutions

These discs are recommended to remove defects while providing optimum dust extraction:



3M Xtract™ Cubitron™ II  
Net Disc 710W



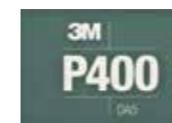
3M Xtract™ Cubitron™ II  
Film Disc 775L



3M Xtract™ Film Disc  
360L

#### 3M™ Hookit™ Flexible Abrasive Hand Sheet 270J

Comes in a variety of grades for different substrates:



#### 3M™ Perfect-it™ Paint Finishing System

Cover steps during large clearcoat repair processes to hologram/haze removal:



3M™ Trizact™ Hookit™ Foam  
Abrasive Disc 443SA



3M™ Perfect-it™ EX AC  
Rubbing Compound



3M™ Finesse-it™  
Buffing Pads

# Grinders

# Accessories

## **3M™ Cubitron™ II Fibre Discs**

Fibre Disc 982CX Pro					
	3M ID	3M Stock No.	Dia.* In (mm)	Grade	Max RPM
	60440365868	7100242928	4" x 5/8" (100 x 16)	36+	15,000
	60440365819	7100242886	4" x 5/8" (100 x 16)	36+	15,000
	60440365843	7100242963	4" x 7/8" (100 x 22)	36+	15,000
	60440365694	7100245023	4½" x 7/8" (115 x 22)	36+	13,300
	60440365793	7100242885	4½" x 7/8" (115 x 22)	36+	13,300
	60440365769	7100242974	4½" x TN** (115)	36+	13,300
	60440365850	7100242572	4½" x GL** (115)	36+	13,300
	60440365702	7100242887	5" x 7/8" (125 x 22)	36+	12,000
	60440365785	7100246096	5" x 7/8" (125 x 22)	36+	12,000
	60440365736	7100242968	5" x TN** (125)	36+	12,000
	60440365744	7100242969	5" x GL** (125)	36+	12,000
	60440365835	7100242964	6" x 7/8" (150 x 22)	36+	10,000
	60440365827	7100242966	6" x 7/8" (150 x 22)	36+	10,000
	60440365710	7100242967	7" x 7/8" (180 x 22)	36+	8,600
	60440365777	7100242965	7" x 7/8" (180 x 22)	36+	8,600
	60440365884	7100242927	7" x TN** (180)	36+	8,600
	60440365751	7100242970	7" x GL** (180)	36+	8,600
	60440365728	7100243137	9½" x 7/8" (230 x 22)	36+	6,600
	60440365801	7100243542	9½" x 7/8" (230 x 22)	36+	6,600



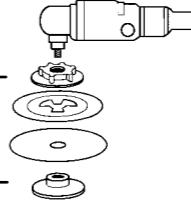
## **3M™ Fibre Discs**

Fibre Disc 787C					
	3M ID	3M Stock No.	Dia.* In (mm)	Grade	Max RPM
	60440312407	7100099275	4½" x 7/8" (115 x 22)	36+	13,300
	60440312498	7100099287	4½" x 7/8" (115 x 22)	60+	13,300
	60440312589	7100099248	4½" x 7/8" (115 x 22)	80+	13,300
	60440312670	7100099280	4½" x 7/8" (115 x 22)	120+	13,300
	60440312415	7100099572	5" x 7/8" (125 x 22)	36+	12,000
	60440312506	7100099288	5" x 7/8" (125 x 22)	60+	12,000
	60440312597	7100099251	5" x 7/8" (125 x 22)	80+	12,000
	60440312688	7100099573	5" x 7/8" (125 x 22)	120+	12,000
	60440312423	7100099276	7" x 7/8" (180 x 22)	36+	8,600
	60440312514	7100099294	7" x 7/8" (180 x 22)	60+	8,600
	60440312605	7100099253	7" x 7/8" (180 x 22)	80+	8,600
	60440312696	7100099281	7" x 7/8" (180 x 22)	120+	8,600
	60440312431	7100099297	9⅛" x 7/8" (230 x 22)	36+	6,600
	60440312522	7100099096	9⅛" x 7/8" (230 x 22)	60+	6,600
	60440312613	7100099255	9⅛" x 7/8" (230 x 22)	80+	6,600
	60440312704	7100099282	9⅛" x 7/8" (230 x 22)	120+	6,600



3M™ Grinders

Power Tool Assembly



1. 3M™ Disc Pad Hub
  2. 3M™ Disc Pad Face Plate
  3. 3M™ Fibre Disc
  4. 3M™ Disc Retainer Nut

## Pneumatic Right-Angle Grinder T27

	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Air Flow Rate SCFM (LPM)	Noise Lvl dBA (pwr)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Inlet Thread	Thread Size	Max RPM
	60440243537	7100142462	28403	4" (100)	1 (744)	37 (1,1048)	86 (98)	3.5 (1.6)	9" (228.6)	5" (127)	3/8" NPT (9.5)	3/8"-24 EXT	12,000
	60440243545	7100142326	28405	4 1/2" (115)	1 (744)	37 (1,1048)	85 (99)	3.7 (1.7)	9" (228.6)	5" (127)	3/8" NPT (9.5)	5/8"-11 EXT	12,000
	60440406472	7100250449	88566	4 1/2"-5" (115- 127)	1.5 (1,100)	43 (1,218)	89 (97)	5.3 (2.4)	11" (279.4)	4" (100)	3/8" NPT (9.5)	5/8"-11 EXT	12,000
	60440406563	7100250448	88577	4 1/2"-5" (115- 127)	1.5 (1,100)	43 (1,218)	89 (97)	4.9 (2.2)	11" (279.4)	4" (100)	3/8" NPT (9.5)	5/8"-11 EXT	12,000

## Accessories for 3M™ Right-Angle Systems

Disc Pad Hub



Digitized by srujanika@gmail.com

## Disc Pad Face Plates



	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Color	Description	For Use With	Max RPM
	60440237489	7000045279	28443	4½" (115)	Red	Ribbed, extra hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	13,300
	60980108249	7000144144	14270	4½" (115)	Black	Smooth, hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	13,300
	60980108264	7000120517	81732	5" (127)	Red	Ribbed, extra hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	12,000
	60980108272	7000120518	81733	5" (127)	Black	Ribbed, hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	12,000
	60980108223	7000028419	80514	7" (178)	Red	Ribbed, extra hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	8,600
	60980108215	7000120514	80515	7" (178)	Black	Ribbed, hard	Fibre Discs and Scotch-Brite™ Surface Conditioning Discs	8,600

Disc Retainer Nut



	<b>3M ID</b>	<b>3M Stock No.</b>	<b>Part No.</b>	<b>Size In (mm)</b>	<b>Thread Size</b>	<b>For Use With</b>	<b>Max RPM</b>
	60980038180	7000120474	02618	5/16" Depth (8)	5/8"-11 INT	3M™ Disc Pad Face Plates and Disc Pad Hubs	n/a
	60980108397	7000120523	05622	3/8" Depth (10)	5/8"-11 INT	3M™ Disc Pad Face Plates and Disc Pad Hubs	n/a

## Disc Backup Pad (TN Quick Change)



	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thread Size	For Use With	Max RPM
	60980105013	7000045746	56573	4½" (115)	5/8"-11 INT	4½" TN Discs (114.3)	13,300

## 3M™ Roloc™ Cloth Disc Selection Guide

Choose the right disc for the job								
Product	Mineral Type	Features	Metal Type	Performance	G	LG	B	D
984F	Precision Shaped Ceramic	Durable 2-ply backing; Grinding aid; Fastest cutting	All Metals	Premium	●	●	●	●
987C	Precision Shaped Ceramic	Best in class performance; Grinding aid	Stainless Steel	Premium	●	●	●	●
947A	Precision Shaped Ceramic	Durable 2-ply backing; Grinding aid	Stainless Steel and Aluminum	Premium	●	●	●	●
787C	Precision Shaped Ceramic	Grinding aid	Stainless Steel	Advanced	●	●	●	●
782C	Precision Shaped Ceramic	Performance and value	Carbon Steel	Advanced	●	●	●	●
361F	Aluminum Oxide	General purpose grinding, light grinding, blending and deburring on all metals	All Metals	Good	●	●	●	●

G=Grinding

LG=Light Grinding

B=Blending

D=Deburring

## 3M™ Roloc™ Surface Conditioning Disc Guide

Choose the right disc for the job								
	Load Resistance Long lasting on flat parts and softer substrates	General Purpose The original multi-purpose surface conditioning disc	Tough Long lasting on parts with sharp edges					
More Aggressive ↑ ↓ Finer Finish	<ul style="list-style-type: none"> <li>AL CRS (Orange)</li> <li>AL MED (Yellow-green)</li> <li>AL VFN (Green)</li> </ul>	<ul style="list-style-type: none"> <li>SC CRS (Red)</li> <li>SC MED (Orange)</li> <li>SC VFN (Purple)</li> </ul>	<ul style="list-style-type: none"> <li>LGB SD (Dark Blue)</li> <li>LGB HD (Blue)</li> <li>SE CRS (Light Blue)</li> <li>SE MED (Medium Blue)</li> <li>SE FIN (Dark Blue)</li> </ul>					

## 3M™ Cubitron™ II Roloc™ Durable Edge Discs

TR (Plastic Button) 984F							
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Feature	Backing	Application
	60440230120	7000045166	1½" (38)	36+	3M™ Precision Shaped Ceramic Grain, durable edge, grinding aid	Y weight polyester cloth, 2-ply cloth, durable edge	Medium/high stock removal, medium/low pressure
	60440230203	7000045171	1½" (38)	60+			
	60440230286	7000045175	1½" (38)	80+			
	60440230138	7100001474	2" (50)	36+	3M™ Precision Shaped Ceramic Grain, durable edge, grinding aid	Y weight polyester cloth, 2-ply cloth, durable edge	Medium/high stock removal, medium/low pressure
	60440230211	7100001475	2" (50)	60+			
	60440230294	7100001473	2" (50)	80+			
	60440230146	7000045167	3" (76)	36+	3M™ Precision Shaped Ceramic Grain, durable edge, grinding aid	Y weight polyester cloth, 2-ply cloth, durable edge	Medium/high stock removal, medium/low pressure
	60440230229	7000045172	3" (76)	60+			
	60440230302	7000045176	3" (76)	80+			

## 3M™ Cubitron™ II Roloc™ Durable Edge Discs

TR (Plastic Button) 947A							
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Feature	Backing	Application
	60440256372	7100077038	1½" (38)	40+	3M™ Precision Shaped Ceramic Grain blend, durable edge, grinding aid	X weight poly-cotton cloth, 2-ply cloth, durable edge	Medium stock removal, medium pressure
	60440256455	7100077046	1½" (38)	60+			
	60440256539	7100076924	1½" (38)	80+			
	60440305062	7100076932	1½" (38)	120+			
	60440256380	7100077039	2" (50)	40+	3M™ Precision Shaped Ceramic Grain blend, durable edge, grinding aid	X weight poly-cotton cloth, 2-ply cloth, durable edge	Medium stock removal, medium pressure
	60440256463	7100077047	2" (50)	60+			
	60440256547	7100076925	2" (50)	80+			
	60440305070	7100076933	2" (50)	120+			
	60440256398	7100077040	3" (76)	40+	3M™ Precision Shaped Ceramic Grain blend, durable edge, grinding aid	X weight poly-cotton cloth, 2-ply cloth, durable edge	Medium stock removal, medium pressure
	60440256471	7100076898	3" (76)	60+			
	60440305005	7100076926	3" (76)	80+			
	60440305088	7100076934	3" (76)	120+			

## Scotch-Brite™ Roloc™ Clean and Strip XT Pro Discs

TR (Plastic Button) Extra Cut XC-DR						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM
	61500303344	7100179815	2" (50)	Extra Coarse	Green	18,000
	61500303369	7100173790	3" (76)	Extra Coarse	Green	15,000
TR (Plastic Button) XO-DR						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM
	61500303302	7100175521	2" (50)	Extra Coarse	Purple	18,000
	61500303328	7100173795	3" (76)	Extra Coarse	Purple	15,000

# Unitized Wheels

## **Specialty Products**

# Scotch-Brite™ Roloc™ EXL Unitized Wheels

TR (Plastic Button) XL-UR						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Feature	Application
	61500099231	7100000860	2" (50)	2A MED	Varying density for application, used on edge or face without adjustment	Deburring and weld blending (finishing)
	61500099215	7000045976	2" (50)	2S FIN		
	61500099272	7000045979	2" (50)	6A MED		
	61500099298	7000045978	2" (50)	8A MED		
	61500099249	7100000858	3" (76)	2A MED	Varying density for application, used on edge or face without adjustment	Deburring and weld blending (finishing)
	61500099223	7100005209	3" (76)	2S FIN		
	61500099280	7000028469	3" (76)	6A MED		
	61500099306	7000045981	3" (76)	8A MED		

## **Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheels**

TR (Plastic Button)					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
 A circular plastic button with a textured surface. The word "Scotch-Brite" is printed in red across the center, and "Scotch" is printed vertically along the sides.	61500311719	7000046303	2" x NH (50)	9C CRS+	22,100
	61500299310	7000046276	3" x NH (76)	9C CRS+	15,100
	61500311727	7000028561	3" x NH (76)	9C XRS+	15,100

## **Scotch-Brite™ Roloc™ Deburr and Finish Pro Unitized Wheels**

TR (Plastic Button) DP-UR						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Thickness In (mm)	Max RPM
	61500302494	7010365721	2" x NH (50)	2S FIN	0.25" (6.4)	22,100
	61500301561	7100086108	2" x NH (50)	4C MED+	0.25" (6.4)	22,100
	61500301264	7100081368	2" x NH (50)	6C MED+	0.125" (3.2)	22,100
	61500301272	7100081367	2" x NH (50)	6C MED+	0.25" (6.4)	22,100
	61500302239	7100109131	2" x NH (50)	8C CRS+	0.25" (6.4)	22,100
	61500302510	7010329346	3" x NH (76)	2S FIN	0.25" (6.4)	15,100
	61500301579	7010295274	3" x NH (76)	4C MED+	0.25" (6.4)	15,100
	61500301298	7100081366	3" x NH (76)	6C MED+	0.125" (3.2)	15,100
	61500301280	7100081365	3" x NH (76)	6C MED+	0.25" (6.4)	15,100
	61500302221	7100109130	3" x NH (76)	8C CRS+	0.125" (3.2)	15,100
	61500302247	7100109110	3" x NH (76)	8C CRS+	0.25" (6.4)	15,100

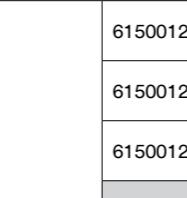
## **Scotch-Brite™ Unitized Wheels**

Laser Braze Finishing Wheel LB-UW							
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Thickness In (mm)	Center Hole In (mm)	Max RPM
	61500315207	7100126882	8" (203)	CRS+	0.11" (2.7)	1" (25.4)	5,500
	61500314556	7100115797	8" (203)	CRS+	0.18" (4.5)	1" (25.4)	5,500
	61500314564	7100115526	8" (203)	CRS+	0.17" (4.2)	1" (25.4)	5,500
	61500314572	7100115983	8" (203)	CRS+	0.15" (3.7)	1" (25.4)	5,500
	61500314580	7100115525	8" (203)	CRS+	0.14" (3.5)	1" (25.4)	5,500
	61500314598	7100115836	8" (203)	CRS+	0.13" (3.2)	1" (25.4)	5,500
	61500314606	7100115834	8" (203)	CRS+	0.12" (3.0)	1" (25.4)	5,500
	61500314614	7100115833	8" (203)	CRS+	0.11" (2.8)	1" (25.4)	5,500
	61500314622	7100115824	8" (203)	CRS+	0.11" (2.7)	1" (25.4)	5,500

## **Unitized Wheel EXL PRO**

	<b>3M ID</b>	<b>3M Stock No.</b>	<b>Dia. In (mm)</b>	<b>Grade</b>	<b>Thickness In (mm)</b>	<b>Center Hole In (mm)</b>	<b>Max RPM</b>
	61500318656	7100133733	8" (203)	8A CRS	0.11" (2.7)	1" (25.4)	5,500
	61500318532	7100133791	8" (203)	8A CRS	0.13" (3.2)	1" (25.4)	5,500
	61500318540	7100133793	8" (203)	8A CRS	0.14" (3.5)	1" (25.4)	5,500
	61500318557	7100133777	8" (203)	8A CRS	0.15" (3.7)	1" (25.4)	5,500
	61500318763	7100133720	8" (203)	8A CRS	0.16" (4.0)	1" (25.4)	5,500
	61500318565	7100133775	8" (203)	8A CRS	0.17" (4.2)	1" (25.4)	5,500
	61500302270	7100136383	8" (203)	8A CRS	0.18" (4.5)	1" (25.4)	5,500

## **Scotch-Brite™ Roloc™ Bristle Discs**

TR (Plastic Button) RD-ZB						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM
	61500129830	7000000740	1" (25)	50	Green	30,000
	61500129913	7100138319	1" (25)	80	Yellow	30,000
	61500129954	7000000741	1" (25)	120	White	30,000
	61500135423	7100138285	2" (50)	50	Green	25,000
	61500135407	7100138284	2" (50)	80	Yellow	25,000
	61500137379	7100138286	2" (50)	120	White	25,000
	61500295342	7100138305	3" (76)	50	Green	15,000
	61500295367	7100138307	3" (76)	80	Yellow	15,000
	61500295359	7100138306	3" (76)	120	White	15,000

## **Scotch-Brite™ Radial Bristle Discs**

Bristle Brush RB-ZB							
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Width In (mm)	Color	Max RPM
	61500139391	7100138323	3" (76)	50	3/8" (9.5)	Green	25,000
	61500139409	7100138324	3" (76)	80	3/8" (9.5)	Yellow	25,000
	61500139417	7000000749	3" (76)	120	3/8" (9.5)	White	25,000
	61500151446	7100138290	6" (152)	36	1/2" (12.7)	Brown	6,000
	61500151461	7100138347	6" (152)	50	1/2" (12.7)	Green	6,000
	61500151479	7100138291	6" (152)	80	1/2" (12.7)	Yellow	6,000
	61500190204	7100138337	7 <sup>5</sup> / <sub>8</sub> " (194)	80	1" (25.4)	Yellow	6,000
	61500190212	7100138338	7 <sup>5</sup> / <sub>8</sub> " (194)	120	1" (25.4)	White	6,000
	61500189479	7100138335	7 <sup>5</sup> / <sub>8</sub> " (194)	220	1" (25.4)	Red	6,000
	61500189487	7100138336	7 <sup>5</sup> / <sub>8</sub> " (194)	400	1" (25.4)	Blue	6,000
	61500189446	7100138332	8" (203)	50	1" (25.4)	Green	6,000
	61500189453	7100138333	8" (203)	80	1" (25.4)	Yellow	6,000
	61500189461	7100138334	8" (203)	120	1" (25.4)	White	6,000

All sizes available in multiple diameters and arbor holes. 3", 4", 6" and 9" sizes also available.

# Die Grinders

# Roloc™ Tools

## 3M™ Abrasive Wheel Power Tools

### Die Grinder: 0.3 HP 224W

	3M ID	3M Stock No.	Part No	Noise Level dBA (power)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Inlet Thread	Air Flow Rate SCFM (LPM)	Collet Size	Max RPM
	60440242497	7100075513	28630	86 (98)	2.3 (1.0)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	17 (481)	1/4"*	25,000
	60440242489	7100075512	28629	78 (90)	1.9 (0.9)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	17 (481)	1/4"*	25,000
	60440242471	7100075511	28628	80 (92)	3.3 (1.5)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	17 (481)	1/4"*	18,000
	60440242463	7100075510	28627	79 (91)	2.2 (1.0)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	17 (481)	1/4"*	18,000

\*Includes 1/8" collet insert (PN55772)

### Die Grinder: 0.5 HP 372W

	3M ID	3M Stock No.	Part No	Noise Level dBA (power)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Inlet Thread	Air Flow Rate SCFM (LPM)	Collet Size	Max RPM
	60440242505	7100075514	28330	87 (99)	2.2 (1.0)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	26 (736)	1/4"*	18,000
	60440242513	7100075201	28331	87 (99)	2.6 (1.2)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	26 (736)	1/4"*	18,000*
	60440242521	7100075515	28332	87 (99)	2.9 (1.3)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	26 (736)	1/4"*	4,000

\*With extension

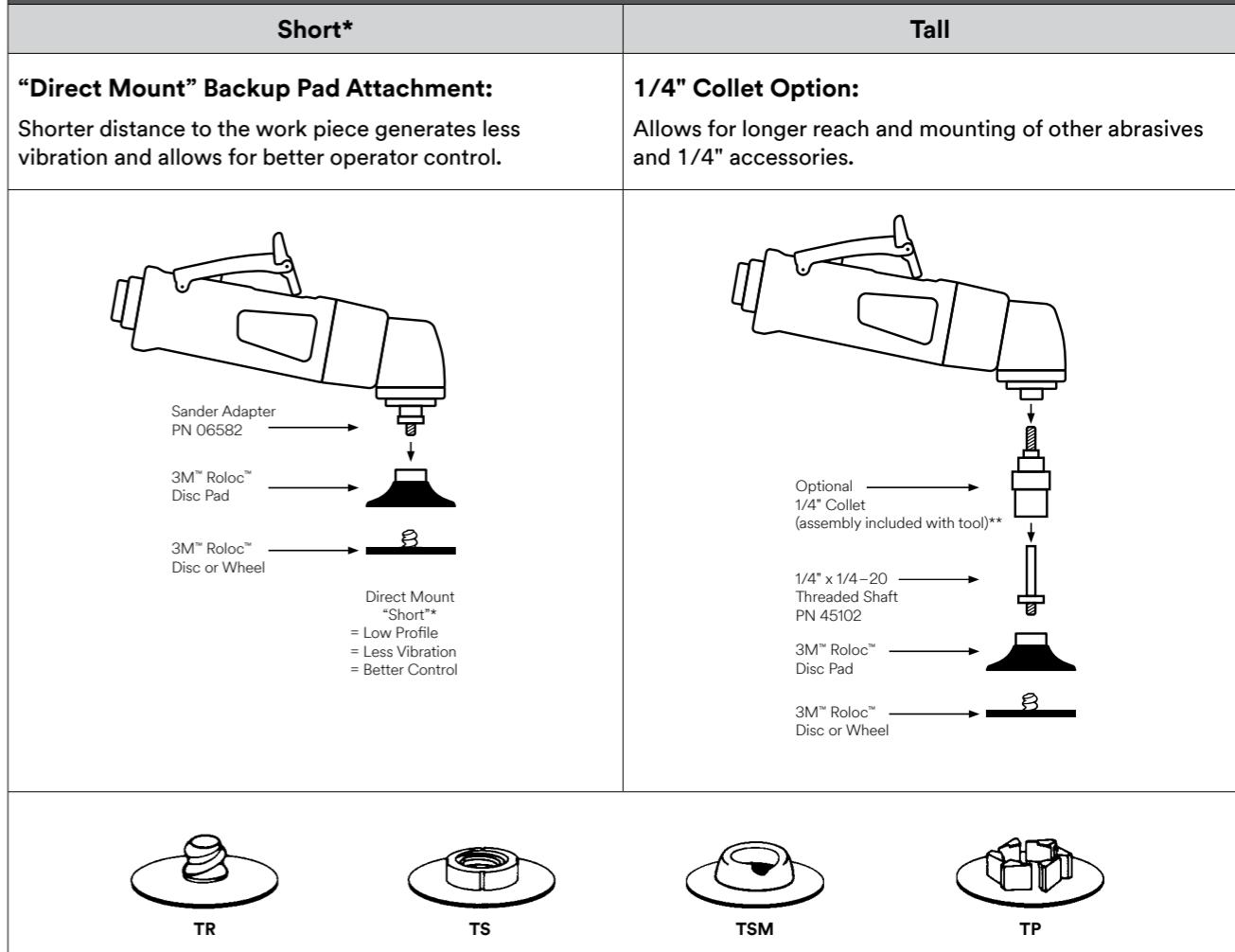
### Die Grinder: 1 HP 744W

	3M ID	3M Stock No.	Part No	Noise Level dBA (power)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Inlet Thread	Air Flow Rate SCFM (LPM)	Collet Size	Max RPM
	60440243180	7100109085	20237	86 (98)	3.9 (1.8)	12.5" (317.5)	4.6" (116.8)	3/8" NPT (9.5)	37 (1,048)	1/4"*	20,000
	60440243198	7100106791	20238	89 (101)	3.9 (1.8)	12.5" (317.5)	4.6" (116.8)	3/8" NPT (9.5)	37 (1,048)	1/4"*	18,000
	60440243214	7100142494	28770	84 (95)	2.8 (1.3)	13" (330.2)	4.6" (116.8)	3/8" NPT (9.5)	37 (1,048)	1/4"*	18,000
	60440243487	7100142323	20239	n/a	3.3 (1.5)	12.5" (317.5)	4.6" (116.8)	3/8" NPT (9.5)	37 (1,048)	1/4"*	12,000
	60440243495	7100142324	20240	n/a	3.4 (1.5)	12.5" (317.5)	4.6" (116.8)	3/8" NPT (9.5)	37 (1,048)	1/4"*	8,000

\*Available in metric collet

## 3M™ Roloc™ Attachment Systems

### Versatile Attachment System



\*Direct mount to disc pad \*\*For other collet inserts, see Owner's Manual for part numbers

### Collet Insert Availability for Die Grinder

Part No.	HP	RPM	Length	Collet Insert Size and Part Number								
				1/8" (06573)	1/8" (55772)	3/16" (06574)	1/4" (06575)	1/4" (55752)	3/8" (06545)	3mm (06576)	6mm (06577)	8mm (06546)
28630	0.3	25,000	Extended	●				●				
28629	0.3	25,000	Regular		●				●			
28628	0.3	18,000	Extended		●				●			
28627	0.3	18,000	Regular		●				●			
28330	0.5	18,000	Regular	●			●	●		●	●	●
28331	0.5	18,000	Extended		●				●			
28332	0.5	4,000	Regular	●			●	●		●	●	●
20237	1	20,000	Regular	●			●	●		●	●	●
20238	1	18,000	Regular	●			●	●		●	●	●
28770	1	18,000	Extended	●			●	●		●	●	●
20239	1	12,000	Regular	●			●	●		●	●	●
20240	1	8,000	Regular	●			●	●		●	●	●

### 3M™ Roloc™ System Power Tools

Disc Sander													
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Air Flow Rate SCFM (LPM)	Noise Lvl dBA (pwr)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Inlet Thread	Collet Size	Max RPM
	60440242422	7100075502	28341	2" (50)	0.3 (224)	17 (481)	81 (92)	2.4 (1.1)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	1/4"	20,000
	60440242430	7100075503	28328	2"-3" (50-76)	0.3 (224)	17 (481)	81 (92)	1.8 (0.8)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	1/4"	12,000
	60440242448	7100075504	20231	2" (50)	0.5 (372)	26 (736)	89 (101)	2.4 (1.1)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	1/4"	20,000
	60440242455	7100075505	28329	2"-3" (50-76)	0.5 (372)	26 (736)	89 (101)	2.4 (1.1)	12.5" (317.5)	4.6" (116.8)	1/4" NPT (6.35)	1/4"	12,000
	60440243503	7100142325	20232	2"-3" (50-76)	1 (744)	37 (1,048)	84 (95)	3.6 (1.6)	12.5" (317.5)	4.6" (116.8)	3/8" NPT (9.5)	1/4"	15,000

# Roloc™ Accessories

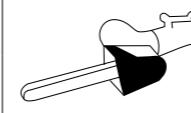
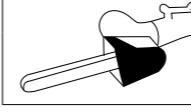
# File Belts

## 3M™ Roloc™ System Accessories

TR (Plastic Button) Disc Pad									
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thread Size	Density Rtg	For Use With	Max RPM	
	60980037943	7100003161	45101	1" (25)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	30,000	
	60440237588	7000045280	45099	1½" (38)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	30,000	
	60440237794	7000045286	45100	1½" (38)	1/4"-20 INT	Hard	3M™ Roloc™ TR Discs	30,000	
	60440237653	7000045282	45095	2" (50)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	25,000	
	60440237786	7000000441	45096	2" (50)	1/4"-20 INT	Hard	3M™ Roloc™ TR Discs	25,000	
	60440237737	7000045284	45097	2" (50)	1/4"-20 INT	Extra Hard	3M™ Roloc™ TR Discs	25,000	
	60440237661	7000000602	45092	3" (76)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	18,000	
	60440237778	7000045285	45091	3" (76)	1/4"-20 INT	Hard	3M™ Roloc™ TR Discs	20,000	
	60440237745	7000045285	45093	3" (76)	1/4"-20 INT	Extra Hard	3M™ Roloc™ TR Discs	20,000	
	Cool Running Disc Pad								
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thread Size	Density Rtg	For Use With	Max RPM	
	60440239261	7010362528	82974	2" (50)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	20,000	
	60440240368	7010362544	28711	2" (50)	1/4"-20 INT	Hard	3M™ Roloc™ TR Discs	20,000	
	60980018265	7010309116	82975	3" (76)	1/4"-20 INT	Medium	3M™ Roloc™ TR Discs	12,000	
	60440240350	7010308606	28710	3" (76)	1/4"-20 INT	Hard	3M™ Roloc™ TR Discs	12,000	
Shank									
	3M ID	3M Stock No.	Part No.	Thread Size		For Use With		Max RPM	
	60980108116	7000045770	45102	1/4"-20 EXT		3M™ Roloc™ Disc Pads with 1/4"-20" INT		n/a	
Roloc™+ Holder									
	3M ID	3M Stock No.	Part No.	Description In (mm)		For Use With		Max RPM	
	61500078169	7000045946	15408	1" Dia. x 1/4" shaft diameter (25 x 6)		3M™ Roloc™ Unitized Wheels, Roloc™+ products, brush and disc accessories		25,000	
Vacuum Hose Anti-Static									
	3M ID	3M Stock No.	Part No.	Description In (mm)		For Use With		Max RPM	
	60440240566	7010362547	28730	1" ID x 4' length (25 x 1219), 1" EXT hose thread (25)		3M™ Roloc™ Unitized Wheels, Roloc™+ products, brush and disc accessories		n/a	
Over Hose Kit									
	3M ID	3M Stock No.	Part No.	Description		For Use With		Max RPM	
	60440239717	7010308603	28651	Kit Contains: Air Line Extension (PN 20209), Adapter (PN 20453), Overhose Cloth Sleeve, Exhaust Spacer, Air Inlet Bushing, instruction sheet		0.3 HP Die Grinders		n/a	

For Finesse-it™ Roloc™ solutions, see Finesse-it™ on pages 62-65

## 3M™ Coated Abrasive Belt Selection Guide

Portable File Belt									
	Material Finishing			Recommended			Alternative		Finishing/Polishing
	Carbon Steel/Cast Iron			784F			947A		384F
	Stainless Steel/Cobalt Chrome			784F			947A		384F
	Aluminum/Soft Substrates			981F			784F		384F
	Titanium			967F			784F		947A
Recommended Backings for Portable File Belt									
	Scotch-Brite™ DF Surface Conditioning Belt			Scotch-Brite™ SC Surface Conditioning Belt			Scotch-Brite™ SE Surface Conditioning Belt		
	Scrim	Low Stretch	Film Backed	Scrim	Low Stretch	Film Backed	Scrim	Low Stretch	Film Backed

● Recommended Starting Point ■ Recommended Alternative

## 3M™ Cubitron™ II File Belts

Cloth Belt 784F				
	3M ID	3M Stock No.	Size In (mm)	Grade
	60440316044	7100122768	1/2" x 18" (12 x 457)	36+
	60440332140	7100122891	1/2" x 18" (12 x 457)	60+
	60440332181	7100119302	1/2" x 18" (12 x 457)	80+
	60440332223	7100146282	1/2" x 18" (12 x 457)	120+
	60440334849	7010414999	3/4" x 18" (19 x 457)	36+
	60440332108	7100119295	3/4" x 18" (19 x 457)	60+
	60440332173	7100128758	3/4" x 18" (19 x 457)	80+
	60440332272	7010362614	3/4" x 18" (19 x 457)	120+

## Scotch-Brite™ Low Stretch File Belts

Durable Flex (DF) Surface Conditioning Belt					
	3M ID	3M Stock No.	Size In (mm)	Grade	Color
	61500296019	7000121140	3/4" x 18" (19 x 457)	A CRS	Brown
	61500295854	7000121130	3/4" x 18" (19 x 457)	A MED	Maroon
	61500295938	7100105418	3/4" x 18" (19 x 457)	A FIN	Green

# Abrasive Belt Systems

# Sanding Discs

## 3M™ Power Tools

File Belt Sander												
	3M ID	3M Stock No.	Part No.	Motor	Belt Speed SFFPM (SMM)	Weight Pound (kg)	Length In (mm)	Height In (mm)	Width In (mm)	Air Flow Rate SCFM (LPM)	Max RPM	
	60440236689	7000000433	28366	0.6 (447)	4990 (1521)	2.8 (1.3)	14.57 (370.1)	2.93 (74.4)	5.95 (151.1)	28 (793)	22,000	
File Belt Sander Kit												
	60440236697	7000000434	28367	Kit includes: molded case, File Belt Sander (PN28366) and two attachment arms (PN28368, PN28370)								

## 3M™ Power Tool Accessories

File Belt Arm Service Tool Kit					
	3M ID	3M Stock No.	Part No.	Description	Use With Belt Size In (mm)
	60440248601	7000119406	30670	Contains Wheel Positioning Block, Shaft Removal Tool, 2 Bearing Removal Tools, Bearing Mount Tool, Bearing Tools and Retaining Compound	
File Belt Sander Attachment Arm					
	60440236705	7000119295	28368	<b>Standard Style:</b> Standard arm included with 3M™ File Belt Sander (PN28366); sand with contact wheel or platen	1/2" x 18" (12 x 457)
	60440236713	7000119296	28369	<b>Thin Style:</b> Thinner than standard arm; sand with contact wheel or platen	1/2" x 18" (12 x 457)
	60440236721	7000119297	28370	<b>Corners Style:</b> Sand corners and grooves with contact wheel; accommodates three belt widths	1/8" x 18", 1/4" x 18", 1/2" x 18" (3 x 457, 6 x 457, 12 x 457)
	60440236739	7000000435	28371	<b>Thick Standard Style:</b> Thicker than standard arm; sand with contact wheel or platen; accommodates two belt widths	5/8" x 18", 3/4" x 18" (15 x 457, 19 x 457)
	60440236747	7000000436	28372	<b>Corners Style:</b> Sand corners and grooves with contact wheel; accommodates two belt widths	1/8" x 18", 1/4" x 18" (3 x 457, 6 x 457)
	60440236762	7000000438	28374	<b>Curved Arm:</b> Unique curved arm used for blending flat areas; sand with contact wheel or platen	1/2" x 18" (12 x 457)
	60440236770	7000000439	28375	<b>Vessel Arm:</b> Unique large arm used for blending weld seams; sand with 4" contact wheel; includes tracking/control knob; accommodates two belt widths	1/4" x 24", 1/2" x 24" (6 x 609, 12 x 609)
	60440236788	7000119298	28376	<b>Sander Extension:</b> Use to extend arms to 24" length; can be used with same attachment arm used for 18" length arms	1/2" x 24" (12 x 609)

## 3M™ Random Orbital Sanding Disc Selection Guide

Choose the right disc for the job		
Premium Series (longer life)	Advanced Series (better finish)	Standard Series (faster cut)
<p><b>3M Xtract™ Cubitron™ II Film Disc 775L</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic</li> <li>3 mil film</li> <li>80+ – 400+ grades</li> </ul>	<p><b>3M™ Film Disc 375L</b></p>  <ul style="list-style-type: none"> <li>Aluminum oxide</li> <li>5 mil film (60 – P400 grades)</li> <li>3 mil film (&gt;P400 grades)</li> <li>60 – P1500 grades</li> </ul>	<p><b>3M Xtract™ Paper Disc 236U</b></p>  <ul style="list-style-type: none"> <li>General purpose; all applications</li> <li>Aluminum oxide</li> <li>C-weight paper</li> <li>P80 – P500 grades</li> </ul>
<p><b>3M Xtract™ Cubitron™ II Paper Disc 732U</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic</li> <li>C-weight paper</li> <li>80+ – 220+ grades</li> </ul>	<p><b>3M™ Blue Abrasive Disc 321U</b></p>  <ul style="list-style-type: none"> <li>Ceramic and aluminum oxide blend</li> <li>C-weight paper (80 – 800 grades)</li> <li>D-weight (40 grade)</li> <li>40 – 800 grades</li> </ul>	<p><b>3M™ Paper Disc 216U</b></p>  <ul style="list-style-type: none"> <li>General purpose; all applications</li> <li>Aluminum oxide</li> <li>A-weight paper</li> <li>P80 – P800 grades</li> </ul>
<p><b>3M™ Cubitron™ II Cloth Disc 784F</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic</li> <li>YF-weight cloth</li> <li>36+ – 120+ grades</li> </ul>	<p><b>3M™ Cloth Disc 341D</b></p>  <ul style="list-style-type: none"> <li>Aluminum oxide</li> <li>X-weight cloth</li> <li>36 – P180 grades</li> </ul>	
<p><b>3M Xtract™ Cubitron™ II Net Disc 710W</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic and aluminum oxide</li> <li>Net backing</li> <li>80+ - 320+ grades</li> </ul>	<p><b>3M Xtract™ Cubitron™ II Net Disc 310W</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic</li> <li>Net backing</li> <li>80+ - 320+ grades</li> </ul>	
<p><b>3M Xtract™ Cubitron™ II Heavy Duty Net Disc 700W</b></p>  <ul style="list-style-type: none"> <li>Precision-shaped ceramic</li> <li>Net backing</li> <li>80+ and 120+ grades</li> </ul>		

# 3M Xtract™ Discs

## 3M Xtract™ Cubitron™ II Net Discs

Net Disc 710W					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440602278	7100249604	3" x NH (76)	80+	15,000
	60440602286	7100249593	3" x NH (76)	120+	15,000
	60440602294	7100247538	3" x NH (76)	150+	15,000
	60440602302	7100249602	3" x NH (76)	180+	15,000
	60440602310	7100249596	3" x NH (76)	220+	15,000
	60440602328	7100249603	3" x NH (76)	240+	15,000
	60440602336	7100249605	3" x NH (76)	320+	15,000
	60440602146	7100249601	5" x NH (127)	80+	12,000
	60440602153	7100249591	5" x NH (127)	120+	12,000
	60440602161	7100249592	5" x NH (127)	150+	12,000
	60440602179	7100249590	5" x NH (127)	180+	12,000
	60440602187	7100249594	5" x NH (127)	220+	12,000
	60440602195	7100249599	5" x NH (127)	240+	12,000
	60440602203	7100249600	5" x NH (127)	320+	12,000
	60440602013	7100249502	6" x NH (152)	80+	12,000
	60440602021	7100249503	6" x NH (152)	120+	12,000
	60440602039	7100249508	6" x NH (152)	150+	12,000
	60440602047	7100249506	6" x NH (152)	180+	12,000
	60440602054	7100249505	6" x NH (152)	220+	12,000
	60440602062	7100249510	6" x NH (152)	240+	12,000
	60440602070	7100249509	6" x NH (152)	320+	12,000
Heavy Duty Net Disc 700W					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440407447	7100252412	5" x NH (127)	60+	12,000
	60440407454	7100249825	5" x NH (127)	80+	12,000
	60440407462	7100249822	5" x NH (127)	120+	12,000
	60440407413	7100253253	6" x NH (152)	60+	12,000
	60440407421	7100249823	6" x NH (152)	80+	12,000
	60440407439	7100252418	6" x NH (152)	120+	12,000

## 3M Xtract™ Cubitron™ II Net Discs

Net Disc 310W					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440407322	7100250824	3" x NH (76)	60+	15,000
	60440602658	7100247531	3" x NH (76)	80+	15,000
	60440602666	7100247099	3" x NH (76)	120+	15,000
	60440602674	7100247100	3" x NH (76)	150+	15,000
	60440602682	7100247102	3" x NH (76)	180+	15,000
	60440602690	7100247530	3" x NH (76)	220+	15,000
	60440602708	7100247535	3" x NH (76)	240+	15,000
	60440602716	7100247536	3" x NH (76)	320+	15,000
	60440602526	7100247537	5" x NH (127)	60+	12,000
	60440602534	7100247534	5" x NH (127)	80+	12,000
	60440602542	7100247101	5" x NH (127)	120+	12,000
	60440602559	7100247528	5" x NH (127)	150+	12,000
	60440602567	7100247523	5" x NH (127)	180+	12,000
	60440602575	7100247526	5" x NH (127)	220+	12,000
	60440602583	7100247573	5" x NH (127)	240+	12,000
	60440602591	7100247522	5" x NH (127)	320+	12,000
	60440602393	7100247527	6" x NH (152)	60+	12,000
	60440602401	7100252419	6" x NH (152)	80+	12,000
	60440602419	7100252417	6" x NH (152)	120+	12,000
	60440602427	7100247529	6" x NH (152)	150+	12,000
	60440602435	7100247524	6" x NH (152)	180+	12,000
	60440602443	7100247525	6" x NH (152)	220+	12,000
	60440602450	7100247532	6" x NH (152)	240+	12,000
	60440602468	7100247533	6" x NH (152)	320+	12,000

## 3M Xtract™ Cubitron™ II Film Discs

Film Disc 775L					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440315715	7100106678	3" (76)	80+	15,000
	60440315723	7100106714	3" (76)	120+	15,000
	60440315731	7100106717	3" (76)	150+	15,000
	60440315178	710011238	3" (76)	180+	15,000
	60440315749	7100106716	3" (76)	220+	15,000
	60440335515	7100145460	3" (76)	240+	15,000
	60440335523	7100145433	3" (76)	320+	15,000
	60440347924	7100145452	3" (76)	400+	15,000
	60440296196	7100045070	5" (127)	80+	12,000
	60440296204	7100045071	5" (127)	120+	12,000
	60440255788	7100064175	5" (127)	150+	12,000
	60440255846	7100064177	5" (127)	180+	12,000
	60440255903	7100064270	5" (127)	220+	12,000
	60440335382	7100145362	5" (127)	240+	12,000
	60440335226	7100145363	5" (127)	320+	12,000
	60440347908	7100145404	5" (127)	400+	12,000
	60440296212	7100045072	6" (152)	80+	12,000
	60440296220	7100045073	6" (152)	120+	12,000
	60440255796	7100065918	6" (152)	150+	12,000
	60440255853	7100064178	6" (152)	180+	12,000
	60440255911	7100064271	6" (152)	220+	12,000
	60440335390	7100145316	6" (152)	240+	12,000
	60440335234	7100141692	6" (152)	320+	12,000
	60440347916	7100145455	6" (152)	400+	12,000

## 3M Xtract™ Cubitron™ II Paper Discs

Paper Disc 732U					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440296477	7100044448	5" (127)	80+	12,000

## 3M Xtract™ Discs

### 3M Xtract™ Film Discs

Film Disc 360L					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440140873	7100010252	3" (76)	P220	12,000
	60440140881	7100010254	3" (76)	P240	12,000
	60440140907	7100010256	3" (76)	P320	12,000
	60440140915	7100010259	3" (76)	P400	12,000
	60440140923	7000118631	3" (76)	P500	12,000
	60440140931	7100010261	3" (76)	P600	12,000
	60440140949	7100010262	3" (76)	P800	12,000
	60440140956	7100010263	3" (76)	P1000	12,000
	60440139180	7010029941	5" (127)	P220	12,000
	60440139115	7100077547	5" (127)	P240	12,000
	60440139123	7100028668	5" (127)	P280	12,000
	60440139198	7010029942	5" (127)	P320	12,000
	60440139206	7010029943	5" (127)	P400	12,000
	60440139131	7010029937	5" (127)	P500	12,000
	60440139149	7010029938	5" (127)	P600	12,000
	60440139156	7010029939	5" (127)	P800	12,000
	60440139164	7010029940	5" (127)	P1000	12,000
	60440140659	7100077620	6" (152)	P220	12,000
	60440140667	7100077621	6" (152)	P240	12,000
	60440140675	7010029944	6" (152)	P280	12,000
	60440140683	7100077622	6" (152)	P320	12,000
	60440140691	7100077623	6" (152)	P400	12,000
	60440140709	7100077624	6" (152)	P500	12,000
	60440140717	7100077625	6" (152)	P600	12,000
	60440140725	7100077626	6" (152)	P800	12,000
	60440140733	7100077975	6" (152)	P1000	12,000

### 3M Xtract™ Paper Discs

Paper Disc 236U					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440273088	7000119599	3" (76)	P80	12,000
	60440273096	7000119600	3" (76)	P100	10,000
	60440273104	7000119601	3" (76)	P120	12,000
	60440273112	7000119602	3" (76)	P150	10,000
	60440273120	7000119603	3" (76)	P180	12,000
	60440273138	7000119604	3" (76)	P220	12,000
	60440273146	7000119605	3" (76)	P240	10,000
	60440273153	7000119606	3" (76)	P320	12,000
	60440273161	7000119607	3" (76)	P400	10,000
	60440273179	7000119608	3" (76)	P500	10,000
	XAO12057650	7010029926	5" (127)	P80	12,000
	XAO12057668	7010029927	5" (127)	P100	12,000
	XAO12057676	7010029928	5" (127)	P120	12,000
	XAO12057684	7010029929	5" (127)	P150	12,000
	XAO12057692	7010029930	5" (127)	P180	12,000
	XAO12057700	7010029931	5" (127)	P220	12,000
	XAO12057718	7010029932	5" (127)	P240	12,000
	XAO12057726	7010029933	5" (127)	P320	12,000
	XAO12057734	7010029934	5" (127)	P400	12,000
	XAO12057742	7010029935	5" (127)	P500	10,000
	XAO12057759	7100078152	6" (152)	P80	12,000
	XAO12057767	7100078153	6" (152)	P100	12,000
	XAO12057775	7100078154	6" (152)	P120	12,000
	XAO12057783	7100078155	6" (152)	P150	12,000
	XAO12057791	7100078156	6" (152)	P180	12,000
	XAO12057809	7100078157	6" (152)	P220	12,000
	XAO12057817	7100078158	6" (152)	P240	12,000
	XAO12057825	7100078159	6" (152)	P320	12,000
	XAO12057833	7100078180	6" (152)	P400	12,000
	XAO12057841	7100078181	6" (152)	P500	10,000

## 3M Xtract™ Tools/Accessories

### 3M Xtract™ Pneumatic Random Orbital Sanders

Central Vacuum					
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Orbit Dia. In (mm)
	60440604969	7100258884	88941	5" (127)	3/32" (2.5)
	60440604977	7100258886	88942	5" (127)	3/16" (5)
	60440604985	7100258885	88943	5" (127)	5/16" (8)
	60440604993	7100258887	88944	5" (127)	3/8" (10)
	60440605081	7100259232	88953	6" (152)	3/32" (2.5)
	60440605099	7100258801	88954	6" (152)	3/16" (5)
	60440605107	7100258707	88955	6" (152)	5/16" (8)
	60440605115	7100258799	88956	6" (152)	3/8" (10)
Self-Generated Vacuum					
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Orbit Dia. In (mm)
	60440605008	7100258112	88945	5" (127)	3/32" (2.5)
	60440605016	7100258783	88946	5" (127)	3/16" (5)
	60440605024	7100258784	88947	5" (127)	5/16" (8)
	60440605032	7100258785	88948	5" (127)	3/8" (10)
	60440605123	7100258708	88957	6" (152)	3/32" (2.5)
	60440605131	7100258798	88958	6" (152)	3/16" (5)
	60440605149	7100259323	88959	6" (152)	5/16" (8)
	60440605156	7100258842	88960	6" (152)	3/8" (10)

# 3M Xtract™ Tools/Accessories

## 3M Xtract™ Random Orbital Sander Accessories

Filter Bag and Adapter					
	3M ID	3M Stock No.	Part No.	Description	
	60440243990	7100263231	89137	Large filter bag — HEPA-rated (holds up to 0.5 lbs.) (8oz)	
	60440244006	7100263030	89139	XLarge filter bag — HEPA-rated (holds up to 3 lbs.) (48oz)	
	60440236671	7000028217	28365	Backpack assembly (holds PN28364)	
	60440236853	7000042706	28383	Filter bag end cap — 1" Dia. (25.4mm)	
	60440128308	7000000361	20453	Filter bag adapter — 1" EXT hose thread x 1" Dia. (25.4mm x 25.4mm)	
	60440189102	7000118731	A0778	Hose seal	
Paper Vacuum Bag and Adapter					
	3M ID	3M Stock No.	Part No.	Description	
	60440127102	7000045003	20338	Paper vacuum bag inserts, green — collects dust when using Self-Gen Vacuum Sander	
	60440236036	7000045249	28303	Vacuum bag cover — holds and protects paper vacuum bag inserts (PN20338)	
	60440236028	7000045248	28302	Vacuum hose adapter — connects 1" EXT vacuum hose to paper vacuum inserts (PN2038)	
Vacuum Hose					
	3M ID	3M Stock No.	Part No.	Description	
	60440240566	7010362547	28730	Black, anti-static	
	60440236010	7000045247	28301	Red	
Vacuum Hose Adapter					
	3M ID	3M Stock No.	Part No.	End 1 In (mm)	End 2 In (mm)
	60440247975	7000119372	30442	1" INT Thread (25.4)	1" INT Thread (25.4)
	60440127128	7000045004	20340	1" INT Thread (25.4)	1¼" INT Thread (31.8)
	60440236044	7000045250	28304	1" EXT Thread (25.4)	1" Push-On (25.4)
	60440246795	7000045309	30324	1" INT Thread (25.4)	3/4" Push-On (19.5)
	60440127136	7000045005	20341	1" INT Thread (25.4)	1½" Push-On (38.1)
	60440247967	7000045312	30441	1" Push-On (25.4)	1¼" Push-On (31.8)
	60440247959	7000045311	30440	1" Push-On (25.4)	1½" Push-On (38.1)
	60440247942	7000045310	30439	1" Push-On (25.4)	2" Push-On (50.8)

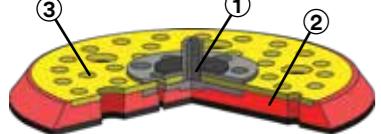
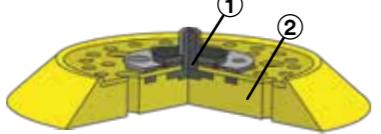
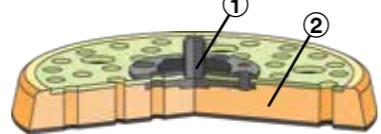
# 3M Xtract™ Tools/Accessories

## 3M Xtract™ Self-Generated and Central Vacuum Sanding Systems

Assembly Instructions				
<b>3M Xtract™ Self-Generated Vacuum Sanding System</b>	→  →	Choose one	Large Filter Bag PN89137	XLarge Filter Bag PN89139
	Self-Generated Vacuum Exhaust PNA0778	Filter Bag Adapter PN20453	Backpack Assembly PN28365	
<b>3M Xtract™ Self-Generated Vacuum Sanding System with Paper Bags</b>	→  →		Paper Vacuum Bag Insert PN20338	Vacuum Bag Cover PN28303
	Self-Generated Vacuum Exhaust	3M Vacuum Hose	Vacuum Hose Adapter PN28302	
<b>3M Xtract™ Central Vacuum Sanding System</b>	→  →			Central Vacuum System
	Self-Generated Vacuum Exhaust	3M Vacuum Hose	Vacuum Hose Adapter	

# 3M Xtract™ Tools/Accessories

## 3M Xtract™ Hookit™ Disc Pads Shape Profile

Red — Firm (Most Aggressive)	Yellow — Medium (General Purpose)	Beige — Soft (Best Finish)
		
<b>Low Profile Design</b> Firm red foam for stock removal and leveling	<b>Standard Design</b> Tapered edge and medium yellow foam for blending and feather edging	<b>Low Profile Finishing Design</b> Soft beige foam for better finish and conformance
1. One-piece stud design for improved balance and reduced vibration 2. Color-coded pads with customized features make it simpler to achieve the exact finish desired 3. Upgraded hole placement for clean sanding pads for the ultimate in dust extraction		

## 3M Xtract™ Hookit™ Disc Pads

Backup Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440128100	7100009656	20206	5" (127)	1/2" (12.7)	5/16"-24 EXT	31	Medium	1	12,000 (12,000)		
Low Profile Finishing Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440241440	7100009657	20290	5" (127)	11/16" (17.5)	5/16"-24 EXT	44	Soft	1	12,000 (12,000)		
Low Profile Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440241150	7100037832	20353	5" (127)	3/8" (9.5)	5/16"-24 EXT	44	Firm	2	12,000 (12,000)		
Low Profile Disc Pad 861 Plus												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440241143	7100022038	20465	6" (152)	3/8" (9.5)	5/16"-24 EXT	49	Firm	2	12,000 (12,000)		
Soft Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440241416	7000118613	20425	6" (152)	1/2" (12.7)	5/16"-24 EXT	53	Soft	1	10,000 (12,000)		
Low Profile Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440241135	7100027464	20356	6" (152)	3/8" (9.5)	5/16"-24 EXT	52	Firm	2	12,000 (12,000)		

# Hookit™ Pads

## 3M™ Hookit™ Interface Pads

Interface Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Center Hole In (mm)	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440236234	7100009701	28323	5" (127)	1/2" (12.7)	3/4" (19.1)	31	Medium	3	12,000 (12,000)		
Soft Interface Pad												
	60455031264	7000028239	05777	6" (152)	1/2" (12.7)	3/4" (19.1)	25	Soft	3	12,000 (12,000)		
Soft Interface Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Center Hole In (mm)	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440128118	7100006170	20278	5" (127)	1/2" (12.7)	3/4" (19.1)	31	Soft	3	12,000 (12,000)		
	60440236218	7100009658	28321	5" (127)	1/2" (12.7)	n/a	44	Soft	2	12,000 (12,000)		
	60440236226	7100005497	28322	6" (152)	1/2" (12.7)	n/a	52	Soft	2	12,000 (12,000)		

## 3M™ Hookit™ Disc Pad Hook Savers

Disc Pad Hook Saver												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	# of Holes	Hook Type	Max RPM (OPM)					
	60440128217	7000045012	20444	5" (127)	44	2	12,000 (12,000)					
	60440128209	7000045011	20443	5" (127)	31	2	12,000 (12,000)					
	60440128233	7000042703	20446	6" (152)	52	2	12,000 (12,000)					
	60440128225	7000118615	20445	6" (152)	25	2	12,000 (12,000)					

# Hookit™/Stikit™ Discs

## 3M™ Cubitron™ II Stikit™ Film Discs

Film Disc Roll 775L					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440296071	7100045901	5" x NH (127)	80+	12,000
	60440296089	7100045902	5" x NH (127)	120+	12,000
	60440255960	7100067206	5" x NH (127)	150+	12,000
	60440256000	7100067208	5" x NH (127)	180+	12,000
	60440256042	7100075693	5" x NH (127)	220+	12,000
	60440335325	7100145429	5" x NH (127)	240+	12,000
	60440335259	7100145417	5" x NH (127)	320+	12,000
	60440347957	7100145435	5" x NH (127)	400+	12,000
	60440296097	7100046309	6" x NH (152)	80+	10,000
	60440296105	7100046320	6" x NH (152)	120+	10,000
	60440298481	7100067212	6" x NH (152)	150+	12,000
	60440298473	7100067211	6" x NH (152)	180+	12,000
	60440299018	7100067078	6" x NH (152)	220+	12,000
	60440335333	7100145428	6" x NH (152)	240+	12,000
	60440335440	7100145467	6" x NH (152)	320+	12,000
	60440347973	7100145454	6" x NH (152)	400+	12,000

## Lined Film Disc w/Tabs 775L

	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440295990	7100048736	5" x NH (127)	80+	12,000
	60440296006	7100045865	5" x NH (127)	120+	12,000
	60440255952	7100075678	5" x NH (127)	150+	12,000
	60440255994	7100075690	5" x NH (127)	180+	12,000
	60440256034	7100075692	5" x NH (127)	220+	12,000
	60440335283	7100145374	5" x NH (127)	240+	12,000
	60440335242	7100145365	5" x NH (127)	320+	12,000
	60440348005	7100145364	5" x NH (127)	400+	12,000
	60440296014	7100045866	6" x NH (152)	80+	10,000
	60440296022	7100045867	6" x NH (152)	120+	10,000
	60440298523	7100075207	6" x NH (152)	150+	10,000
	60440298515	7100075206	6" x NH (152)	180+	10,000
	60440299034	7100075221	6" x NH (152)	220+	10,000
	60440335291	7100145372	6" x NH (152)	240+	12,000
	60440335465	7100145432	6" x NH (152)	320+	12,000
	60440347999	7100145474	6" x NH (152)	400+	12,000

Discs with holes also available

## 3M™ Cubitron™ II Hookit™ Film Discs

Film Disc 775L					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440315673	7100106742	3" (76)	80+	15,000
	60440315681	7100106764	3" (76)	120+	15,000
	60440315707	7100106762	3" (76)	150+	15,000
	60440315756	7100106768	3" (76)	180+	15,000
	60440315707	7100106766	3" (76)	220+	15,000
	60440335499	7100145430	3" (76)	240+	15,000
	60440335507	7100145431	3" (76)	320+	15,000
	60440347890	7100145477	3" (76)	400+	15,000
	60440296154	7100046325	5" (127)	80+	12,000
	60440296162	7100046326	5" (127)	120+	12,000
	60440255770	7100064174	5" (127)	150+	12,000
	60440255838	7100064176	5" (127)	180+	12,000
	60440255895	7100064179	5" (127)	220+	12,000
	60440335366	7100145403	5" (127)	240+	12,000
	60440335218	7100145405	5" (127)	320+	12,000
	60440347874	7100145436	5" (127)	400+	12,000
	60440296170	7100046327	6" (152)	80+	10,000
	60440296188	7100046328	6" (152)	120+	10,000
	60440298408	7100064273	6" (152)	150+	12,000
	60440298390	7100064272	6" (152)	180+	12,000
	60440298879	7100064274	6" (152)	220+	10,000
	60440335374	7100145407	6" (152)	240+	12,000
	60440335408	7100145462	6" (152)	320+	12,000
	60440347882	7100145469	6" (152)	400+	12,000

# Hookit™/Stikit™ Discs

## 3M™ Cubitron™ II Hookit™ Paper Discs

Paper Disc 732U					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440296394	7100044450	5" (127)	80+	12,000
	60440296402	7100044785	5" (127)	120+	12,000
	60440255804	7100066674	5" (127)	150+	12,000
	60440255861	7100066677	5" (127)	180+	12,000
	60440255929	7100066700	5" (127)	220+	12,000
	60440296410	7100044153	6" (152)	80+	12,000
	60440296428	7100044452	6" (152)	120+	12,000
	60440298614	7100067093	6" (152)	150+	12,000
	60440298622	7100067094	6" (152)	180+	12,000
	60440298929	7100075213	6" (152)	220+	12,000

Discs with holes also available

## 3M™ Cubitron™ II Stikit™ Paper Discs

Paper Disc Roll 732U					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440296311	7100045903	5" (127)	80+	12,000
	60440296329	7100045904	5" (127)	120+	12,000
	60440255986	7100067207	5" (127)	150+	12,000
	60440256026	7100067209	5" (127)	180+	12,000
	60440256067	7100067210	5" (127)	220+	12,000
	60440296337	7100045905	6" (152)	80+	12,000
	60440296345	7100045340	6" (152)	120+	12,000
	60440298655	7100067075	6" (152)	150+	12,000
	60440298663	7100067076	6" (152)	180+	12,000
	604402989				

# Hookit™ Discs

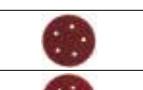
## 3M™ Cubitron™ II Hookit™ Cloth Discs

Plain Cloth Disc 947A						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Holes	Max RPM
	60440333668	7100113114	3" (76)	40+	None	15,000
	60440333676	7100113109	3" (76)	60+	None	15,000
	60440333684	7100113126	3" (76)	80+	None	15,000
	60440333692	7100113117	3" (76)	120+	None	15,000
	60440333700	7100113120	5" (127)	40+	None	12,000
	60440333718	7100113137	5" (127)	60+	None	12,000
	60440333726	7100112980	5" (127)	80+	None	12,000
	60440333734	7100085514	5" (127)	120+	None	12,000
	60440333742	7100113121	6" (152)	40+	None	12,000
	60440333759	7100113142	6" (152)	60+	None	12,000
	60440333767	7100113080	6" (152)	80+	None	12,000
	60440333775	7100113139	6" (152)	120+	None	12,000

## Cloth Disc w/Holes 947A

	3M ID	3M Stock No.	Dia. In (mm)	Grade	Holes	Max RPM
	60440333783	7100113118	3" (76)	40+	3 Holes	15,000
	60440333791	7100113119	3" (76)	60+	3 Holes	15,000
	60440333809	7100113145	3" (76)	80+	3 Holes	15,000
	60440333817	7100113113	3" (76)	120+	3 Holes	15,000
	60440333825	7100113110	5" (127)	40+	5 Holes	12,000
	60440333833	7100113096	5" (127)	60+	5 Holes	12,000
	60440333841	7100113111	5" (127)	80+	5 Holes	12,000
	60440333858	7100113075	5" (127)	120+	5 Holes	12,000
	60440333866	7100113143	6" (152)	40+	6 Holes	12,000
	60440333874	7100113076	6" (152)	60+	6 Holes	12,000
	60440333882	7100113107	6" (152)	80+	6 Holes	12,000
	60440333890	7100113871	6" (152)	120+	6 Holes	12,000

## Scotch-Brite™ Hookit™ Pro Discs

Pro Disc 7447						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Holes	Max RPM
	61500301165	7010329874	5" (127)	A VFN	None	12,000
	61500301173	7010300879	6" (152)	A VFN	None	8,600
	61500301751	7010329332	5" (127)	A VFN	5 Holes	12,000
	61500301769	7010292688	6" (152)	A VFN	6 Holes	12,000

# Hookit™ Discs/Sheets

## 3M™ Hookit™ Abrasive Discs

Flexible Abrasive Disc 270J					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60455081657	7100180074	6" (152) with holes	P320	12,000
	60455072649	7000120193	6" (152) with holes	P400	12,000
	60455072656	7000120194	6" (152) with holes	P600	12,000
	60455072664	7000120195	6" (152) with holes	P800	12,000
	60455072672	7000120196	6" (152) with holes	P1000	12,000
	60455072680	7000120197	6" (152) with holes	P1200	12,000
	60455072698	7000120198	6" (152) with holes	P1500	12,000
	60455081665	7100169504	6" (152) with holes	P2000	12,000
	60455109102	7100203836	5" (127) plain	P400	12,000
	60455109094	7100203837	5" (127) plain	P600	12,000
	60455101877	7100169733	6" (152) plain	P320	12,000
	60455088736	7100104547	6" (152) plain	P400	12,000
	60455088744	7100104516	6" (152) plain	P600	12,000
	60455088751	7100104515	6" (152) plain	P800	12,000
	60455088769	7100104330	6" (152) plain	P1000	12,000
	60455088777	7100104331	6" (152) plain	P1200	12,000
	60455088785	7100104332	6" (152) plain	P1500	12,000
	60455101885	7100169734	6" (152) plain	P2000	12,000

## 3M™ Hookit™ Abrasive Sheets

Flexible Abrasive Hand Sheet 270J				
	3M ID	3M Stock No.	Size In (mm)	Grade
	60455081442	7100180073	5.5" x 6.8" (139 x 172)	P320
	60455069991	7100010553	5.5" x 6.8" (139 x 172)	P400
	60455070007	7100010566	5.5" x 6.8" (139 x 172)	P600
	60455070015	7100010567	5.5" x 6.8" (139 x 172)	P800
	60455070023	7100010569	5.5" x 6.8" (139 x 172)	P1000
	60455070031	7100010568	5.5" x 6.8" (139 x 172)	P1200
	60455070049	7100010565	5.5" x 6.8" (139 x 172)	P1500
	60455081467	7100179991	5.5" x 6.8" (139 x 172)	P2000

## 3M™ Hookit™ Foam Discs

Flexible Abrasive Foam Disc					
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Grade
	UU006388860	7100100149	33550	3" (76)	P800
	UU006388852	7100100148	33551	3" (76)	P1000
	UU007819327	7100100158	33552	3" (76)	P1200
	UU007819335	7100100159	33553	3" (76)	P1500
	UU007819343	7100100160	33554	3" (76)	P2000
	UU006389066	7100100157	33545	5" (127)	P800
	UU006389223	7100100155	33546	5" (127)	P1000
	UU006389215	7100100154	33547	5" (127)	P1200
	UU006388902	7100100153	33548	5" (127)	P1500
	UU006388886	7100100150	335		

# Hookit™ Discs

## 3M™ Hookit™ Interface Pads

Interface Disc Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Center Hole In (mm)	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440236234	7100009701	28323	5" (127)	1/2" (12.7)	3/4" (19.1)	31	Medium	3	12,000 (12,000)		
Soft Interface Pad												
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Center Hole In (mm)	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60455037782	7000000490	05771	3" (76)	1/2" (12.7)	n/a	6	Soft	3	15,000 (15,000)		
	60455031264	7000028239	05777	6" (152)	1/2" (12.7)	3/4" (19.1)	25	Soft	3	12,000 (12,000)		
Soft Interface Disc Pad												
	3M ID	3M Stock No.	Part No.	Size In (mm)	Thickness	Center Hole In (mm)	# of Holes	Density Rating	Hook Type	Max RPM (OPM)		
	60440128118	7100006170	20278	5" Dia. (127)	1/2" (12.7)	3/4" (19.1)	31	Soft	3	12,000 (12,000)		
	60440236218	7100009658	28321	5" Dia. (127)	1/2" (12.7)	n/a	44	Soft	2	12,000 (12,000)		
	60440236226	7100005497	28322	6" Dia. (152)	1/2" (12.7)	n/a	52	Soft	2	12,000 (12,000)		

## 3M™ Hookit™ Film Discs

Film Disc 360L						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Center Hole In (mm)	Max RPM
	CY998895296	7100075553	3" (76)	P320	7/8" (22.2)	20,000
	60440333635	7100140894	3" (76)	P400	7/8" (22.2)	15,000
	60440299406	7100093078	3" (76)	P500	7/8" (22.2)	20,000
	CY998891378	7010518140	3" (76)	P500	7/8" (22.2)	20,000
	60440333643	7100136897	3" (76)	P600	7/8" (22.2)	20,000
	60440333650	7100112430	3" (76)	P800	7/8" (22.2)	20,000

## 3M™ Hookit™ Microfinishing Film Discs

Diamond Microfinishing Film Disc 675L						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM
	CY998733398	7010509684	5" x NH (127)	125µm	Orange	12,000
	CY998733653	7010509697	5" x NH (127)	74µm	Blue	12,000
	CY998731111	7010509528	5" x NH (127)	45µm	Yellow	12,000
	CY998734610	7010509778	5" x NH (127)	30µm	Green	12,000
	CY998733406	7010509685	6" x NH (152)	125µm	Orange	12,000
	CY998623227	7010534530	6" x NH (152)	74µm	Blue	12,000
	CY998734057	7010509734	8" x NH (203)	74µm	Blue	12,000
	CY998730543	7010509477	8" x NH (203)	45µm	Yellow	12,000
	CY998612238	7010533440	8" x NH (203)	30µm	Green	12,000

## 3M™ Stikit™ Film Discs

Microfinishing Film Disc 268L						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Center Hole In (mm)	Max RPM
	GC800358878	7000034069	3" (76)	A40	7/8" (22.2)	15,000
	GC800338748	7000034065	3" (76)	A30	7/8" (22.2)	12,000
	GC800358866	7000034070	3" (76)	A20	7/8" (22.2)	15,000
	GC800323104	7000082174	3" (76)	A15	7/8" (22.2)	15,000
	GC800358894	7000082240	3" (76)	A9	7/8" (22.2)	15,000

## 3M™ Trizact™ Hookit™ Film Discs

Film Disc 268XA							
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM	
	60440227910	7000028185	5" x NH (127)	A35	Green	12,000	
	CY998730535	7010509476	5" x NH (127)	A20	Pink	12,000	
	60440227928	7000028186	5" x NH (127)	A10	Blue	12,000	
	60440227936	7000028187	5" x NH (127)	A5	Orange	12,000	
	60440228009	7000028188	5" x NH (127)	n/a	White	12,000	
	60440227944	7000119186	6" x NH (152)	A35	Green	12,000	
	CY998623466	7010534554	6" x NH (152)	A20	Pink	12,000	
	60440227951	7000119187	6" x NH (152)	A10	Blue	12,000	
	60440227969	7000119188	6" x NH (152)	A5	Orange	12,000	
	60440228017	7000119189	6" x NH (152)	n/a	White	12,000	

Other diameters available in both Hookit™ and Stikit™

## 3M™ Trizact™ Film Discs

PSA Film Disc Roll 268XA						
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Color	Max RPM
	60650033743	7000120385	5" x NH (127)	A35	Green	12,000
	60440297988	7000139515	5" x NH (127)	A20	Pink	12,000
	60650033735	7000120384	5" x NH (127)	A10	Blue	12,000
	60650033677	7000120383	5" x NH (127)	A5	Orange	12,000
	60410006641	7010325694	5" x NH (127)	n/a	White	12,000
	60020003541	7000144552	6" x NH (152)	A35	Green	12,000
	CY998623466	7010534554	6" x NH (152)	A20	Pink	12,000
	60020003533	7000144551	6" x NH (152)	A10	Blue	12,000
	60020003558	7000144553	6" x NH (152)	A5	Orange	12,000
	60020003681	7000118191	6" x NH (152)	n/a	White	12,000

Other diameters available in both Hookit

## Hookit™ Hand Pads

### 3M™ Hookit™ Hand Pads

Disc Hand Pad										
	3M ID	3M Stock No.	Part No.	Shape	Dia. In (mm)	Thickness In (mm)	Foam Color	Face Color	Density Rating	
	60510026358	7000028331	01908	Contoured	3" (76)	n/a	Yellow	Yellow	Medium	
	60980023695	7100138316	77750	Round	5" (127)	1" (25.4)	Black	Black	Soft	
	60980108181	7100005515	77752	Round	5" (127)	1/4" (6.4)	Black	Black	Soft	
	60980031342	7000045710	85095	Contoured	5" (127)	n/a	Yellow	Yellow	Firm	
	60980106359	7000120500	88132	Half Round	5" (127)	1/4" (6.4)	Black	Black	Medium	
	60980026706	7000028382	05791	Round	6" (152)	1/4" (6.4)	Black	Black	Soft	
	60440241457	7100049258	28777	Round	8" (203)	1/4" (6.4)	Black	Black	Soft	
Center Water Feed Disc Hand Pad										
	3M ID	3M Stock No.	Part No.	Shape	Dia. In (mm)	Thickness In (mm)	Foam Color	Face Color	Density Rating	
	60980026623	7000000601	82457	Bullet	3" (76)	n/a	Yellow	Yellow	Firm	
	60980105864	7000045752	70147	Contoured	3" (76)	n/a	Yellow	Yellow	Firm	
Center Water Feed Disc Hand Pad Replacement Sponge										
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Length In (mm)	Width In (mm)	Weight Lb (kg)	Color		
	60980015766	7000000581	82191	7/8" (22)	10 3/8" (263)	6 1/8" (165)	.45lb (0.204)	Yellow		

## Stikit™ Hand Pads

### 3M™ Stikit™ Disc Hand Pads

Disc Hand Pad										
	3M ID	3M Stock No.	Part No.	Shape	Dia. In (mm)	Thickness In (mm)	Foam Color	Face Color	Density Rating	
	60980106052	7010364119	06624	Half Round	5" (127)	3/8" (9.5)	Black	Blue	Medium	
	60980108199	7100015524	45188	Round	5" (127)	1/8" (3.2)	Black	Blue	Medium	
	60980108173	7000000639	45189	Round	5" (127)	1/4" (6.4)	Black	Blue	Medium	
	60980024594	7000023963	11063	Round	5" (127)	1" (25.4)	Black	Black	Soft	
	60980023067	7100138315	84229	Round	5" (127)	1" (25.4)	Black	Blue	Soft	
	60410009538	7100067514	45198	Round	6" (152)	1/8" (3.2)	Black	Blue	Medium	
	60980015352	7000028359	05591	Round	6" (152)	1/4" (6.4)	Black	Blue	Medium	
	60980014074	7010299206	05589	Round	6" (152)	1" (25.4)	Black	Black	Soft	
Center Water Feed Disc Hand Pad										
	3M ID	3M Stock No.	Part No.	Shape	Dia. In (mm)	Thickness In (mm)	Center Hole In (mm)	Foam Color	Density Rating	
	60980011864	7000028355	77749	Bullet	3" (76)	7/8" (22.2)	7/8" (22.2)	Orange	Soft	
	60980016764	7000028365	82705	Bullet	3" (76)	7/8" (22.2)	7/8" (22.2)	Yellow	Firm	

### 3M™ Hookit™ Flexible Abrasive Products

Foam Pad					
	3M ID	3M Stock No.	Part No.	Size In (mm)	
	60455070064	7000045570	34349	3" x 5" (76 x 127)	
Interface Foam Pad					
	3M ID	3M Stock No.	Part No.	Size In (mm)	
	60455071914	7000120187	34350	3" x 5" (76 x 127)	

# Random Orbital Sanders

## 3M™ Random Orbital Systems

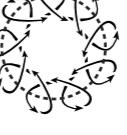
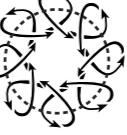
Elite Non-Vacuum Random Orbital Sander														
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Orbit Dia. In (mm)	Motor HP (W)	Noise Lvl dBA (pwr)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Flow Rte SCFM (LPM)	Pad Incl.	Max RPM	
	60410013563	7100025418	28494	3" (76)	3/16" (5)	0.28 (209)	73 (84)	1.52 (0.692)	5.78" (146.8)	3.64" (92.5)	17 (481)	Hookit™ 20350	12,000	
	60440298903	7100095664	87092	3" (76)	3/32" (2.5)	0.28 (209)	73 (84)	1.31 (0.596)	5.78" (146.8)	3.38" (85.9)	17 (481)	Hookit™ 20350	12,000	
	60410013852	7010360624	28583	5" (127)	3/8" (10)	0.28 (209)	74 (85)	1.81 (0.825)	6.77" (172)	3.58" (90.9)	17 (481)	Stikit™ 20351	12,000	
	60440604944	7100258882	88939	5" (127)	5/16" (8)	0.28 (209)	74 (85)	1.8 (0.817)	6.77" (172)	3.58" (90.9)	17 (481)	Stikit™ 20351	12,000	
	60440604928	7100258878	88937	5" (127)	3/16" (5)	0.28 (209)	74 (85)	1.76 (0.8)	6.77" (172)	3.58" (90.9)	17 (481)	Stikit™ 20351	12,000	
	60440604936	7100258881	88938	5" (127)	3/16" (5)	0.28 (209)	74 (85)	1.76 (0.8)	6.77" (172)	3.58" (90.9)	17 (481)	Hookit™ 20352	12,000	
	60440604910	7100258879	88936	5" (127)	3/32" (2.5)	0.28 (209)	74 (85)	1.72 (0.781)	6.77" (172)	3.58" (90.9)	17 (481)	Stikit™ 20351	12,000	
	60440604951	7100258883	88940	5" (127)	3/8" (10)	0.28 (209)	74 (85)	1.72 (0.781)	6.77" (172)	3.58" (90.9)	17 (481)	Stikit™ 20351	12,000	
	60440605073	7100258800	88952	6" (152)	3/8" (10)	0.28 (209)	75 (86)	1.94 (0.881)	7.36" (186.9)	3.58" (90.9)	17 (481)	Stikit™ 20354	12,000	
	60440605065	7100258651	88951	6" (152)	5/16" (8)	0.28 (209)	75 (86)	1.86 (0.884)	7.36" (186.9)	3.58" (90.9)	17 (481)	Stikit™ 20354	12,000	
	60440605057	7100258652	88950	6" (152)	3/16" (5)	0.28 (209)	75 (86)	1.91 (0.869)	7.36" (186.9)	3.58" (90.9)	17 (481)	Stikit™ 20354	12,000	
	60440605040	7100258787	88949	6" (152)	3/32" (2.5)	0.28 (209)	75 (86)	2.1 (0.957)	7.36" (186.9)	3.58" (90.9)	17 (481)	Stikit™ 20354	12,000	
	Elite Self-Generating Vacuum Random Orbital Sander*													
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Orbit Dia. In (mm)	Motor HP (W)	Noise Lvl dBA (pwr)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Flow Rte SCFM (LPM)	Pad Incl.	Max RPM	
	60410013738	7100046338	28511	3" (76)	3/16" (5)	0.28 (209)	85 (96)	1.65 (0.762)	8.22" (208.8)	3.64" (92.5)	17 (481)	Hookit™ 20350	12,000	
	60410013753	7100038057	28513	3" (76)	3/32" (2.5)	0.28 (209)	85 (96)	1.43 (0.651)	8.14" (206.8)	3.44" (87.4)	17 (481)	Hookit™ 20350	12,000	
Elite Central-Vacuum-Ready Random Orbital Sander														
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Orbit Dia. In (mm)	Motor HP (W)	Noise Lvl dBA (pwr)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Air Flow Rte SCFM (LPM)	Pad Incl.	Max RPM	
	60410013654	7000045294	28503	3" (76)	3/16" (5)	0.28 (209)	72 (83)	1.63 (0.742)	7.91" (200.9)	3.64" (92.5)	17 (481)	Hookit™ 20350	12,000	
	60410013670	7100112802	28505	3" (76)	3/32" (2.5)	0.28 (209)	72 (83)	1.41 (0.644)	7.91" (200.9)	3.44" (87.4)	17 (481)	Hookit™ 20350	12,000	

\*One (1) each of the following included: 3M™ Clean Sanding Filter Bag, Filter Bag Adapter, Hose Seal

# Random Orbital Sanders

## 3M™ Random Orbital Sanders

### Select the orbit that's right for your project

<b>3/32" (2.5mm) Diameter Orbit</b> — <b>Chrome Lever</b> fine finish sanding	 
<b>3/16" (5mm) Diameter Orbit</b> — <b>Silver Lever</b> general purpose sanding	 
<b>5/16" (8mm) Diameter Orbit</b> — <b>Black Lever</b> aggressive sanding	 
<b>3/8" (10mm) Diameter Orbit</b> — <b>Gold Lever</b> most aggressive sanding	 

### Basic ROS Techniques

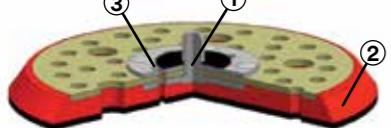
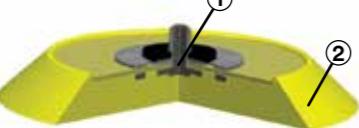
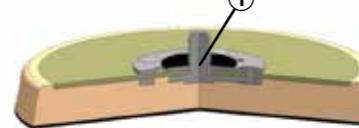
1. Start the tool ON the surface; stop the tool OFF the surface
2. Run the tool flat on work piece (no tipping on edge)
3. Light operator hand pressure (let the tool do the work)
4. North, south, east, west sanding pattern for a uniform, quality finish

### Troubleshooting Checklist

- Check for correct PSI and RPM
- Check airline length, leaks, fitting and inside diameter
- Check tool lubrication schedule
- Look for worn bearings
- Look for damaged disc pad
- Are the tool and disc pad diameter the same?
- Is the lever damaged or the muffler clogged?
- Is the speed control adjuster turned down?

# Hookit™ Accessories

## 3M™ Hookit™ Disc Pads Shape Profile

Red — Firm	Yellow — Medium	Beige — Soft
		
<b>Low Profile Design</b> Firm red foam for stock removal and leveling	<b>Standard Design</b> Tapered edge and medium yellow foam for blending and feather edging	<b>Low Profile Finishing Design</b> Soft beige foam for better finish and conformance
1. One-piece stud design for improved balance and reduced vibration 2. Color-coded pads with customized features make it simpler to achieve the exact finish desired 3. Upgraded hole placement for clean sanding pads for the ultimate in dust extraction		

## 3M™ Hookit™ Disc Pads w/Holes

Low Profile Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Hook Type	Max RPM (OPM)	
	60440127227	7000028147	20350	3" (76)	1/2" (12.7)	1/4"-20 EXT	3	Firm	2	15,000 (15,000)	
Standard Profile Disc Pad											
	60440241382	7100032506	82659	5" (127)	3/4" (19.1)	5/16"-24 EXT	5	Medium	1	12,000 (12,000)	
	60440241390	7100032853	05876	6" (152)	3/4" (19.1)	5/16"-24 EXT	7	Medium	1	12,000 (12,000)	
Low Profile Finishing Disc Pad											
	60440128001	7010360095	20428	3" (76)	3/4" (19.1)	1/4"-20 EXT	6	Soft	1	12,000 (12,000)	
	60440241408	7100028484	77856	5" (127)	11/16" (17.3)	5/16"-24 EXT	5	Soft	1	12,000 (12,000)	

## 3M™ Hookit™ Plain Disc Pads

Low Profile Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	Density Rating	Hook Type	Max RPM (OPM)		
	60440241101	7100026249	20352	5" (127)	3/8" (9.4)	5/16"-24 EXT	Firm		2	12,000 (12,000)	
	60440241119	7100052357	20355	6" (152)	3/8" (9.4)	5/16"-24 EXT	Firm		2	12,000 (12,000)	
Standard Profile Disc Pad											
	60440241465	7100034710	85105	5" (127)	3/4" (19.1)	5/8"-11 INT	Medium		1	12,000 —	
	60440241473	7100041215	85096	5" (127)	5/8" (15.7)	5/8"-11 INT	Medium		1	12,000 —	
	60440241333	7100027274	05775	5" (127)	3/4" (19.1)	5/16"-24 EXT	Medium		1	12,000 (12,000)	
	60440241341	7100041340	70138	6" (152)	3/4" (19.1)	5/16"-24 EXT	Medium		1	12,000 (12,000)	
Low Profile Finishing Disc Pad											
	60440241358	7100035324	77855	5" (127)	11/16" (17.3)	5/16"-24 EXT	Soft		1	12,000 (12,000)	

# Hookit™/Stikit™ Accessories

## 3M™ Hookit™ Disc Pad Hook Savers

Disc Pad Hook Saver							
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	# of Holes	Hook Type	Max RPM (OPM)
	60440236267	7000045251	28326	3" (76)	3	2	15,000 (15,000)
	60440128217	7000045012	20444	5" (127)	44	2	12,000 (12,000)
	60440128209	7000045011	20443	5" (127)	31	2	12,000 (12,000)
	60440128233	7000042703	20446	6" (152)	52	2	12,000 (12,000)
	60440128225	7000118615	20445	6" (152)	25	2	12,000 (12,000)

## 3M™ Stikit™ Disc Pads w/Holes

Low Profile Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Max RPM (OPM)		
	60440241093	7100044784	20442	5" (127)	3/8" (9.5)	5/16"-24 EXT	5	Firm	12,000 (12,000)		
	60440241085	7100119723	20454	6" (152)	3/8" (9.5)	5/16"-24 EXT	6	Firm	12,000 (12,000)		
Standard Profile Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Max RPM (OPM)		
	60440241309	7100045982	45217	5" (127)	3/4" (19.1)	5/16"-24 EXT	5	Medium	10,000 (12,000)		
	60440241317	7100044783	45218	6" (152)	3/4" (19.1)	5/16"-24 EXT	6	Medium	10,000 (12,000)		
Low Profile Finishing Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	# of Holes	Density Rating	Max RPM (OPM)		
	60440241291	7100042435	05645	5" (127)	11/16" (17.5)	5/16"-24 EXT	5	Soft	12,000 (12,000)		
	60440241283	7100024717	05646	6" (152)	11/16" (17.5)	5/16"-24 EXT	6	Soft	10,000 (12,000)		

## 3M™ Stikit™ Plain Disc Pads

Low Profile Disc Pad											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Thickness In (mm)	Thread Size	Density Rtg	Max RPM (OPM)			
	60440127201	7000118609	20348	3" (76)							

## Finesse-it™ Discs

### 3M™ Finesse-it™ Trizact™ Discs

Film Disc Roll 468LA					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	XA006732581	7100115358	1 1/4" (32)	A3	10,000
	XA006732599	7100115361	1 1/4" (32)	A5	10,000
	XA006732607	7100115360	1 1/4" (32)	A7	10,000
	XA006733852	7100115357	1 5/8" (35)	A3	10,000
	XA006733860	7100115363	1 5/8" (35)	A5	10,000
	XA006733878	7100115345	1 5/8" (35)	A7	10,000
Film Disc Roll 466LA					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	60440124141	7000118570	1 1/4" (32)	A3	10,000
	60020006395	7000042701	1 1/4" (32)	A5	10,000
	60020006775	7000118199	1 1/4" (32)	A7	10,000
	60440124133	7100067988	1 5/8" (35)	A3	12,000
	60020008599	7000118209	1 5/8" (35)	A5	12,000
	60020006742	7000118197	1 5/8" (35)	A7	12,000
Film Disc Roll 464LA					
	3M ID	3M Stock No.	Dia. In (mm)	Grade	Max RPM
	XA006711320	7000103646	1 1/4" (32)	A3	10,000
	XA006711304	7000103644	1 1/4" (32)	A5	10,000
	XA006711312	7000103645	1 1/4" (32)	A7	10,000
	XA006710249	7000103642	1 5/8" (35)	A3	10,000
	XA006710256	7000103643	1 5/8" (35)	A5	10,000
	XA006710231	7000103641	1 5/8" (35)	A7	10,000

### 3M™ Stikit™ Roloc™/Finesse-it™ Roloc™ Sanding Pads

Sanding Pad					
	3M ID	3M Stock No.	Dia. In (mm)	Density Rtg	Max RPM
	60980016020	7000045674	1 1/4" (32)	Soft	6,000
	60440250995	7000028224	1 1/4" (32)	Soft	6,000
	60440238693	7000000442	1 1/4" (32)	Medium	10,000
	60980039808	7000045730	1 1/4" (32)	Firm	10,000

### 3M™ Hookit™ Roloc™/Finesse-it™ Roloc™ Disc Pads

Disc Pad					
	3M ID	3M Stock No.	Dia. In (mm)	Density Rtg	Max RPM
	60980106722	7000045755	1 1/16" (27)	Medium	10,000
	60440239766	7100056128	1 1/4" (32)	Medium	10,000
Finishing Disc Pad					
	3M ID	3M Stock No.	Dia. In (mm)	Density Rtg	Max RPM
	60440240806	7100022172	3" (76)	Firm	6,000
	60440240798	7000000573	3" (76)	Firm	6,000

A full range of Finesse-it™ Hookit™ discs are available to support both manual and automated processes. Reach out to your 3M sales professional for further details.

## Finesse-it™ Tools

### 3M™ Finesse-it™ Tools

Mini Orbital Nib Sander											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440240640	7100025315	28737	1 1/4" (32)	0.48 (358)	0.6 (0.3)	8" (193)	4" (104)	8,000	
Mini Random Orbital Sander											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440241952	7100040572	20244	1 1/4" (32)	0.24 (179)	1.0 (0.5)	5" (120)	3" (85)	8,000	
Random Orbital Buffer											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440241960	7100036729	28333	3" (76)	0.45 (336)	1.8 (0.8)	12" (304.8)	3.5" (88.9)	11,000	
Random Orbital Palm Buffer											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440241010	7100097653	28769	3" (76)	0.28 (209)	2.5 (1.2)	12.7" (322.6)	5.3" (134.6)	10,000	
Rotary Buffer											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440239535	7000045302	28631	3" (76)	0.26 (194)	2.1 (0.9)	16" (406.4)	6.7" (170.2)	3,500	
Random Orbital Buffer											
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Motor HP (W)	Weight Lbs (kg)	Length In (mm)	Height In (mm)	Max RPM		
		60440241218	7100062255	28392	5" (127)	0.45 (336)	2.9 (1.3)	16" (406.4)	6.8" (172.7)	10,000	
3M™ Finesse-it™ Robotic Paint Repair System											
Servo Random Orbital Sander											
	3M ID	3M Stock No.	Part No.	Size In (mm)		Max RPM					
		60440403768	7100230884	77539	11.4" x 5.6" x 2.8" (290 x 142 x 70)		12,000				
Servo Random Orbital Buffer											
	3M ID	3M Stock No.	Part No.	Size In (mm)		Max RPM					
		60440403776	7100230885	77540	10.2" x 5.6" x 2.8" (258 x 142 x 70)		12,000				
Active Compliant Tool											
	3M ID	3M Stock No.	Part No.	Size In (mm)		Weight Lbs (kg)					
		60440359333	7100210736	06530	14.4" x 10.4" x 9.1" (366 x 264 x 231)		15.3 (6.9)				

# Finesse-it™ Polishes

## 3M™ Finesse-it™ Polish Selection Guide

Choose the right polish for the job			
	Premium	Advanced	General Purpose
Fastest ↑ ↓ Finest	320 315	K215GP K211 K218	Finishing Material Purple Final Finish Extra Fine Ultra Fine



## 3M™ Finesse-it™ Polishing Compounds

Premium Series 300						
	3M ID	3M Stock No.	Part No.	Color	Description	Size Gal (Liter)
	UU010316352	7100210642	52061	White	Fast; 315	1 (3.875)
	UU010318119	7100210640	52060	Blue	Faster; 320	1 (3.875)
Advanced Series						
	3M ID	3M Stock No.	Part No.	Color	Description	Size Gal (Liter)
	60440243677	7100161182	45428	Green	Finest; K218	1 (3.875)
	60440240574	7100025167	28695	White	Faster; K211	1 (3.875)
	60440243024	7100109036	28881	White	Fastest; K215GP	1 (3.875)
General Purpose Series						
	3M ID	3M Stock No.	Part No.	Color	Description	Size Gal (Liter)
	60440240178	7100042116	28696	White	Finest; Ultra Fine	1 (3.875)
	60440240285	7000000630	06002	White	Fine; Extra Fine	1 (3.875)
	60440242356	7100075516	87877	Gray	Fast; Final Finish	0.26 (1)
	60440242349	7100075470	82878	Gray	Fast; Final Finish	1 (3.875)
	60440240319	7100009019	51056	Purple	Faster; Purple	1 (3.875)
	60440242406	7100075518	81235	White	Fastest; Finishing Material	0.26 (1)
	60440242398	7100075517	13084	White	Fastest; Finishing Material	1 (3.875)

## 3M™ Perfect-it™ Rubbing Compound

EX AC Rubbing Compound					
	3M ID	3M Stock No.	Part No.	Description	Size Gal (Liter)
	60455109433	7100210709	36061	• Extra cutting power • Better performance in extreme climates • Extra performance on extreme paints	1 (3.875)
	60455109425	7100210683	36060		0.25 (0.946)

# Finesse-it™ Pads

## 3M™ Finesse-it™ Buffing Pads Selection Guide

Choose the right pad for the job			
Color	Aggression	Color	Aggression
White	●●●●●●●●	Red	●●●
Gray	●●●●●●●●	Orange	●●●●
Green	●●●●●●●●		

## 3M™ Finesse-it™ Hookit™ Foam Pads

White Foam Pad						
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Description	Max RPM
	60440126435	7010359979	20271	3 1/4" (95)	Open cell white foam, white loop	12,000
	60440237067	7010362494	28401	5 1/4" (133)	Open cell white foam	12,000
Gray Foam Pad						
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Description	Max RPM
	60440242992	7100085948	28878	3 1/4" (80)	Gray foam	12,000
	60440243008	7100085949	28879	3 1/4" (95)	Gray foam	12,000
	60440243016	7100086330	28880	5 1/4" (133)	Gray foam	12,000
	60440242901	7100085944	28873	3 1/2" (90)	Gray foam, flat face	12,000
Green Foam Pad						
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Description	Max RPM
	60440242869	7100082540	28869	3 1/4" (80)	Green foam	12,000
	60440242877	7100082541	28870	3 1/4" (95)	Green foam	12,000
	60440242885	7100082542	28871	5 1/4" (133)	Green foam	12,000
	60440242893	7100082543	28872	3 1/2" (90)	Green foam, flat face	12,000
Red Foam Pad						
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Description	Max RPM
	60440242950	7100086110	28874	3 1/4" (80)	Red foam	12,000
	60440242968	7100085945	28875	3 1/4" (95)	Red foam	12,000
	60440242976	7100085946	28876	5 1/4" (133)	Red foam	12,000
	60440242984	7100085947	28877	3 1/2" (90)	Red foam, flat face	12,000
Orange Foam Pad						
	3M ID	3M Stock No.	Part No.	Dia. In (mm)	Description	Max RPM
	60440126468	7000044996	20274	1 1/2" (38)	Orange foam	12,000
	60980107258	7000000636	02648	3 1/4" (80)	Orange foam, white loop	12,000
	60980108058	7010328348	02648	3 1/4" (80)	Orange foam, black loop	12,000
	60440180523	7000000366	02637	3 1/4" (95)	Orange foam, white loop	12,000
	60980107274	7000028412	02362	5 1/4" (133)	Orange foam, white loop	12,000
	60980108066	7010365394	02362	5 1/4" (133)	Orange foam, black loop	12,000

# PPS™ System

# PPS™ System

## 3M™ PPS™ Series 2.0 System Kits

Spray Cup System Kit*						
	3M ID	3M Stock No.	Part No.	Volume fl oz (mL)	Filter Size	Cup Size
	60455003503	7100134650	26024	28 (850)	200µm	Large
	60455090633	7100135954	26000	22 (650)	200µm	Standard
	60455102305	7100169390	26112	13.5 (400)	200µm	Midi
	60455090658	7100135935	26114	6.8 (200)	200µm	Mini
	60455003586	7100134640	26028	3 (90)	200µm	Micro
	60455003511	7100134637	26325	28 (850)	125µm	Large
	60455003537	7100134645	26301	22 (650)	125µm	Standard
	60455090666	7100135933	26314	6.8 (200)	125µm	Mini
	60455003594	7100134639	26328	3 (90)	125µm	Micro

\*Note: Each kit contains 32 sealing plugs and 1 cup; each lid includes a quarter-turn lid locking system

## 3M™ PPS™ Series 2.0 Cups/Lids

Spray Cup					
	3M ID	3M Stock No.	Part No.	Volume fl oz (mL)	Cup Size
	60455003644	7100134651	26023	28 (850)	Large
	60455003651	7100134653	26001	22 (650)	Standard
	60455003669	7100135960	26122	13.5 (400)	Midi
	60455003677	7100134643	26115	6.8 (200)	Mini

Spray Cup Lid					
	3M ID	3M Stock No.	Part No.	Filter Size	Cup Size
	60455003602	7100135626	26200	200µm	Large, Standard
	60455003628	7100135646	26204	200µm	Midi, Mini, Micro
	60455003610	7100135628	26199	125µm	Large, Standard
	60455003636	7100135625	26205	125µm	Midi, Mini, Micro

\*Note: Each kit contains 32 sealing plugs and 1 cup; each lid includes a quarter-turn lid locking system

## 3M™ PPS™ Series 2.0 Adapters

Most Popular Adapters*					
	3M ID	3M Stock No.	Part No.	Adapter Type	Thread Size
	60455002802	7100135338	26003	S2c	16mm-1.5mm INT
	60455002869	7100135330	26016	S9	16mm-1.5mm EXT
	60455002919	7100135334	26046	S15	3/8"-19 BSP EXT
	60455003131	7100135335	26135	S40	Trapezoidal EXT
	60455003164	7100135337	26139	S43	1/4"-19 BSP EXT

\*Note: Find a complete list of adapters at [3MCollision.com/PPSadapters](http://3MCollision.com/PPSadapters)

# Performance Spray Gun System

## 3M™ Performance Spray Gun System

Spray Gun System with PPS™ 2.0						
	3M ID	3M Stock No.	Part No.	Volume fl oz (mL)	Nozzle Dia. In (mm)	Air Flow Rate SCFM (LPM)
	60455108633	7100228106	26778	22 (650)	1¼" (33)	13 (368)
Spray Gun						
	3M ID	3M Stock No.	Part No.	Opt. Pressure PSI (bar)	Nozzle Dia. In (mm)	Air Flow Rate SCFM (LPM)
	60455108724	7100228104	26832	145 (9.997)	1¼" (33)	13 (368)
Locking Collar						
	3M ID	3M Stock No.	Part No.	Opt. Pressure PSI (bar)	Nozzle Dia. In (mm)	Air Flow Rate SCFM (LPM)
	60455108799	7100228101	26835	145 (9.997)	1¼" (33)	13 (368)
Needle						
	3M ID	3M Stock No.	Part No.	Opt. Pressure PSI (bar)	Nozzle Dia. In (mm)	Air Flow Rate SCFM (LPM)
	60455108757	7100220927	26838	145 (9.997)	1¼" (33)	13 (368)
Rebuild Kit						
	3M ID	3M Stock No.	Part No.	Opt. Pressure PSI (bar)	Nozzle Dia. In (mm)	Air Flow Rate SCFM (LPM)
	60455108781	7100228530	26840	145 (9.997)	1¼" (33)	13 (368)
Atomizing Head Refill Kit						
	3M ID	3M Stock No.	Part No.	Color	Weight oz (g)	Dia. In (mm)
	60455108641	7100206004	26712	Blue	5.7 (161.6)	0.05" INT (1.2)
	60455108658	7100206008	26713	Green	5.7 (161.6)	0.05" INT (1.3)
	60455108666	7100205981	26714	Orange	5.7 (161.6)	0.06" INT (1.4)
	60455108674	7100205984	26716	Purple	5.7 (161.6)	0.06" INT (1.6)
	60455108682	7100206003	26718	Clear	5.7 (161.6)	0.07" INT (1.8)
	60455108690	7100205982	26720	Red	5.7 (161.6)	0.08" INT (2.0)
Atomizing Head Refill Variety Kit						
	3M ID	3M Stock No.	Part No.	Color	Weight oz (g)	Air Flow Rate SCFM (LPM)
	60455108708	7100207178	26730	Multi	6.5 (184.3)	13 (368)

## 3M™ Masking Tapes

High Performance Masking Tape 2693					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	GT500012866	7000088391	Tan	3/4" (18)	180 ft. (55)
	GT500000333	7000088348	Tan	1" (24)	180 ft. (55)
	GT500007064	7000088380	Tan	1½" (36)	180 ft. (55)
	GT500000325	7000088347	Tan	2" (48)	180 ft. (55)
	GT500012858	7000088390	Tan	3" (72)	180 ft. (55)
	GT500015802	7100093911	Tan	4" (100)	180 ft. (55)
High Performance Masking Tape 2380					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	70006285889	7000123904	Tan	1/2" (12)	180 ft. (55)
	GT500015810	7000088413	Tan	3/4" (18)	180 ft. (55)
	GT500015828	7000088414	Tan	1" (24)	180 ft. (55)
	GT500015836	7000088415	Tan	1½" (36)	180 ft. (55)
	GT500015844	7000088416	Tan	2" (48)	180 ft. (55)
	GT500015851	7000088417	Tan	3" (72)	180 ft. (55)
	GT500015869	7000088418	Tan	4" (100)	180 ft. (55)
High Performance Masking Tape 501+					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	UU004238299	7100086765	Purple	3/4" (18)	180 ft. (55)
	UU004238372	7100086194	Purple	1" (24)	180 ft. (55)
	UU004237796	7100086190	Purple	1½" (36)	180 ft. (55)
	UU004237861	7100086764	Purple	2" (48)	180 ft. (55)
	UU004237804	7100086191	Purple	3" (72)	180 ft. (55)
	UU004237812	7100084943	Purple	4" (100)	180 ft. (55)
	70007506853	7010313352	Purple	5" (127)	180 ft. (55)
Performance Masking Tape 301+					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	70006745585	7000124887	Yellow	1/2" (12)	180 ft. (55)
	70006745593	7000124888	Yellow	3/4" (18)	180 ft. (55)
	70006745601	7000124889	Yellow	1" (24)	180 ft. (55)
	70006745619	7000124890	Yellow	1½" (36)	180 ft. (55)
	70006745627	7000124891	Yellow	2" (48)	180 ft. (55)
	70006745635	7000124892	Yellow	3" (72)	180 ft. (55)
	70006745643	7000124893	Yellow	4" (100)	180 ft. (55)
Scotch® Masking Tapes					
Fine Line Tape 4737					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	70006173671	7000123582	Blue	1/2" (12)	108 ft. (33)
	70006173689	7000123583	Blue	3/4" (18)	108 ft. (33)
	70006222239	7010333880	Blue	2" (48)	108 ft. (33)
	70006172152	7000048630	Translucent Blue	3/8" (9.5)	108 ft. (33)
	70006171097	7000048629	Translucent Blue	1/2" (12)	108 ft. (33)
	70006171071	7000048627	Translucent Blue	1" (24)	108 ft. (33)
	70007505319	7010337024	Translucent Blue	48" (1,219)	108 ft. (33)
Fine Line Tape 4735					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	70006180379	7000048652	Orange	3/4" (18)	108 ft. (33)
	70006257490	7000048833	Orange	1" (24)	108 ft. (33)
	70006723426	7000049651	Orange	2" (48)	108 ft. (33)
	70007509899	7010379491	Orange w/Liner	48" (1,219)	755 ft. (230)
Fine Line Tape 218					
	3M ID	3M Stock No.	Color	Width In (mm)	Length Ft (m)
	70006062262	7000028866	Green	1/4" (6)	180 ft. (55)
	70006028669	7000048422	Green	1/2" (12)	180 ft. (55)
	70006028677	7000048423	Green	3/4" (18)	180 ft. (55)
	70006028685	7000001161	Green	1" (24)	180 ft. (55)
	70006028693	7000028860	Green	2" (48)	180 ft. (55)

# Masking Solutions

## 3M™ Masking Film

High Temperature Paint Masking Film 7300					
	3M ID	3M Stock No.	Part No.	Width In (mm)	Length Ft (m)
	70006158714	7000123523	22832	3" (72)	1,500 ft. (457)
	70006172699	7010312298	72105	4" (100)	1,500 ft. (457)
	70016099627	7010379181	55487	5" (127)	1,500 ft. (457)
	70006158722	7100082513	22833	6" (152)	1,500 ft. (457)
	70006158730	7010334191	22834	9" (228)	1,500 ft. (457)
	70006158748	7000123524	22835	12" (305)	1,500 ft. (457)
	70006158763	7000123525	22837	18" (457)	1,500 ft. (457)
	70006403342	7000124214	58070	24" (609)	1,500 ft. (457)
	70006289873	7100205686	45321	28" (711)	1,500 ft. (457)
	70006158789	7000048609	22839	36" (914)	1,500 ft. (457)
	70006403359	7000124215	58071	48" (1,219)	1,500 ft. (457)
Purple Premium PLUS Clear Masking Film					
	3M ID	3M Stock No.	Part No.	Width Ft (m)	Length Ft (m)
	7000033093	7000033093	50988	13 ft. (4)	492 ft. (150)
	7000071806	7000071806	50989	16 ft. (5)	394 ft. (120)

## Scotch® Masking Paper

Steel Gray Masking Paper					
	3M ID	3M Stock No.	Part No.	Width In (mm)	Length Ft (m)
	60455035463	7000045440	06506	6" (152)	1,000 ft. (305)
	60455035489	7010327747	06512	12" (305)	1,000 ft. (305)
	60455035497	7000045441	06518	18" (457)	1,000 ft. (305)
	60455035505	7000045442	06524	24" (609)	1,000 ft. (305)
	60455035539	7000045443	06536	36" (914)	1,000 ft. (305)
	60455037915	7010308763	55491	48" (1,219)	1,000 ft. (305)

## 3M™ Scotchblok™ Masking Paper

Masking Paper					
	3M ID	3M Stock No.	Part No.	Width In (mm)	Length Ft (m)
	70070119873	7000125998	06706	6" (152)	750 ft. (228)
	70070195006	7000051821	06732	12" (305)	180 ft. (55)
	70070094795	7000125989	06712	12" (305)	750 ft. (228)
	70070195014	7000126012	06738	18" (457)	180 ft. (55)
	70070094803	7000051780	06718	18" (457)	750 ft. (228)
	70070119881	7000051787	06736	36" (914)	750 ft. (228)

## 3M™ Dirt Trap

General Surface Protection Material					
	3M ID	3M Stock No.	Part No.	Color	Size In x ft (cm x m)
	60455068639	7100133779	36849	White	4" x 300 ft. (10 x 91)
	60455068647	7100132342	36850	White	6" x 300 ft. (15 x 91)
	60455052575	7000045499	36851	White	14" x 300 ft. (35 x 91)
	60455055107	7000000528	36852	White	28" x 300 ft. (70 x 91)
	60455052542	7000119889	36853	White	56" x 300 ft. (140 x 91)
	60455081673	7100132343	37852	Gray	28" x 30 ft. (70 x 91)
	60455081681	7100132344	37853	Gray	56" x 300 ft. (140 x 91)
Window/Light Protection Material					
	3M ID	3M Stock No.	Part No.	Color	Size In x ft (cm x m)
	60455050363	7000028295	36856	Clear	18" x 100 ft. (45 x 30)
Floor Applicator					
	3M ID	3M Stock No.	Part No.	Width In (cm)	Length In (cm)
	60455054977	7000045516	36865	17" (43)	31" (71)
Extendable Wall Applicator					
	3M ID	3M Stock No.	Part No.	Width In (cm)	Length In (cm)
	60455054985	7000045517	36866	27" (69)	24" (61)
Material Floor Applicator					
	3M ID	3M Stock No.	Part No.	Width In (cm)	Length In (cm)
	60455053193	7000119908	36864	12" (30)	57" (145)
Material Magnetic Dispenser					
	3M ID	3M Stock No.	Part No.	Width In (cm)	Length In (cm)
	60455050371	7100003285	36862	12" (30)	24" (61)
Clear Film Magnetic Dispenser					
	3M ID	3M Stock No.	Part No.	Width In (cm)	Length In (cm)
	60455102032	7100173136	36863	5" (12)	19" (48)

## 3M™ Booth Coating

Spray-On Coating					
	3M ID	3M Stock No.	Part No.	Description	Size Gal (Liter)
	60980109205	7000028421	06839	• Use with any 2.0 spray nozzle • Protects from overspray • Non-tacky formula resists dirt	1 (3.875)

## Miscellaneous

### 3M™ Flexible Diamond Products

Super Abrasive Block 6200J						
	3M ID	3M Stock No.	Width In (mm)	Length In (mm)	Grade	Color
	60980012508	7000045664	2¼" (57)	3¾" (96)	M250	Green
	60980013027	7000045665	2¼" (57)	3¾" (96)	M125	Black
	60980013035	7000000575	2¼" (57)	3¾" (96)	M74	Red
	60980013043	7000000576	2¼" (57)	3¾" (96)	M40	Yellow
	60980013050	7000034094	2¼" (57)	3¾" (96)	M20	White
	60980016558	7000082403	2¼" (57)	3¾" (96)	M10	Blue

### QRS Cloth Disc 6002J

	3M ID	3M Stock No.	Dia. In (mm)	Pattern	Grade	Color
	CY998612063	7010533423	5" x NH (127)	18	M125	Black
	CY998611537	7010533370	6" x NH (152)	B2	M74	Red
	CY998611586	7010533375	6" x NH (152)	B2	M40	Yellow
	CY998734032	7010509732	6" x NH (152)	B2	M125	Black
	CY998734040	7010509733	6" x NH (152)	B2	M250	Green
	CY998623268	7010534534	8" x NH (203)	B2	M125	Black

### 3M™ Wetordry™ Cloth Discs

Cloth Disc 281W				
	3M ID	3M Stock No.	Dia. In (mm)	Grade
	CY998763874	7010511082	5" x NH (127)	P500
	60440295362	7100114549	5" x NH (127)	P800
	638060559734	7000140529	6" x NH (152)	P500
	CY998763759	7010511070	6" x NH (152)	P500
	60510027745	7000045596	6" x NH (152)	P800
	60650004793	7000045611	8" x NH (203)	P500
	60440326100	7100119536	8" x NH (203)	P500
	CY998891725	7010518160	8" x NH (203)	P500
	60650004660	7010363748	8" x NH (203)	P600
	CY998890933	7010518105	8" x NH (203)	P600
	60440326118	7100114079	8" x NH (203)	P600
	CY998890826	7010518097	8" x NH (203)	P800
	60440326126	7010327643	8" x NH (203)	P800
	60650004702	7100024044	8" x NH (203)	P800
	60440143265	7000045052	8" x NH (203)	P1000

### Tabbed Cloth Disc 281W

	3M ID	3M Stock No.	Dia. In (mm)	Grade
	60440319717	7100188645	5" x NH (127)	P500
	60440319709	7100188646	5" x NH (127)	P600
	60440319691	7100192040	5" x NH (127)	P800

## Miscellaneous

### 3M™ Screen Cloth Discs

Hand Pad						
	3M ID	3M Stock No.	Part No.	Size In (mm)	Density Rating	
	60980105674	7100138317	02712	5" x 1" (127 x 25)	Medium	
	60980106664	7100138169	99736	6" x 1" (152 x 25)	Soft	
	60980017127	7100005496	82793	8" x 1" (203 x 25)	Soft	
	60980105682	7100138168	02713	8" x 1" (203 x 25)	Medium	

### 3M™ Brushlon™ Product

Nylon Short Trim 320B						
	3M ID	3M Stock No.	Part No.	Width In (mm)	Length In (cm)	Color
	60440126542	7010308191	20282	16½" (419)	45" (114)	Teal

### Scotch-Brite™ Cut and Polish

Unitized Block						
	3M ID	3M Stock No.	Part No.	Width In (mm)	Length In (mm)	Grade
	61500140191	7010365121	24346	1" (25)	5" (127)	5A Fine

### Scotch-Brite™ Hand Pads

Available in Discs, Sheets, Rolls and Hand Pads						
	3M ID	3M Stock No.	Part No.	Size In (mm)	Color	Grade
	61500299922	7100023339	7447 PRO	6" x 9" Perforated (150 x 228)	Maroon	A VFN
	61500300019	7100023340	7448 PRO	6" x 9" Perforated (150 x 228)	Gray	S ULF



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