

**NEW!**

# **Scotch-Brite™** Match & Finish System



**Easy**  
**does it**

For fast, consistent  
finishing on fabricated  
steel parts



**3M**

**The fast, easy way to get right back to where you started**

Welding, bending, stamping and other fabrication processes can seriously mar the mill finish of stainless steel and other metals – requiring a lot of time and many tricky, painstaking steps to restore the finish to its original condition.

Now, you have a fast, easy way to bring that finish “right back to where you started” – with the introduction of the new 3M™ Match & Finish System.

**Scotch-Brite™  
Match & Finish System**

# Game, set, match!

**An easy-to-use,  
integrated system  
– for a perfect  
finish, every time!**

The heart of the 3M Match & Finish System is a select portfolio of proven Scotch-Brite Flap Brushes, paired with the new 3M™ Match & Finish Sander. When combined with our fast cutting, long-lasting 3M™ Cubitron™ II Discs, Scotch-Brite™ Flap Brushes and other high-performance 3M abrasives, you have a fast, user-friendly system for weld blending and finish restoration on a wide range of metals.

**The easy way to match your finish, every time!**

- Simplifies finish matching
- Easy to control
- Reduces stop/start marks
- Easy screw-on/screw-off attachments
- Optimal conformability



# From weld leveling to final finish in 3 easy steps!

## Recommended starting points



**NEW! 3M™ Cubitron™ II Fibre Disc 987C**  
(Grade 60+, 7" diameter)



**Alternative Selection**  
**NEW! 3M™ Cubitron™ II Roloc™ Durable Edge Disc 984F**  
(Grade 60+, 4" diameter)

### Step 1: Leveling the weld

Level the weld on stainless steel for #3 and #4 finishes with **3M™ Cubitron™ II Discs**.

- Made with 3M precision-shaped ceramic grain, for ultra-fast cut and exceptional life
- Includes a grinding aid for cooler running temperatures

**Work hint:** Use the finest grade of abrasive that gets the job done; finer grind lines are easier to remove. Align the grind line scratches with the grain line direction of the original stock (perpendicular scratches are more difficult to blend).

### Step 2: Setting the grain



**3M™ Belt 777F**  
(Grade P120)

Produce a directional scratch to prepare stainless steel for final finishing with **3M™ Belt 777F**.

- Contains 3M ceramic aluminum oxide blend abrasive grain with polyester cloth backing
- Includes a grinding aid, which enhances performance on stainless steel and exotic alloys

Recommended: Use with 3M™ Match & Finish tool with 3M™ Expander Wheel (PN 28718) and Adapter Kit (PN 28719)

**Work hint:** Attempt to stay as close as possible to the weld area to minimize final blending.



**Choose the Scotch-Brite™ Match & Finish Flap Brush that's right for your application.**

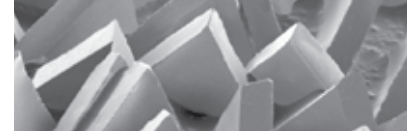
### Step 3: Final finishing

Match your finish with **Scotch-Brite™ Match & Finish Flap Brushes**.

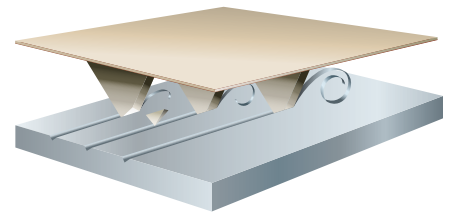
- Easy to control
- Conforms to most surface geometries
- Easy-thread on/off attachment

**Work hint:** With a little practice, you can "feather" in and out of the repair area. Working with the grain, ease off pressure on both ends of the strokes.

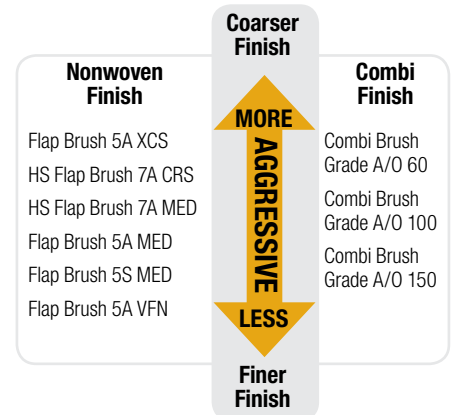
### 3M Precision-Shaped Grain



The new precision-shaped grain found in 3M™ Cubitron™ II abrasives combines the advanced material properties of our original ceramic grain with the precise microreplicated structures pioneered in 3M™ Trizact™ Abrasives. As the triangular shaped grain wears, it continuously fractures to form sharp points and edges. The result is a faster and cooler cut that lasts up to 4 times longer than conventional discs.



### Scotch-Brite™ Match & Finish Flap Brush Selection Guide



**Work hint:** Start with HS CRS or HS MED. If the finish doesn't match, then move to a more aggressive or less aggressive grade.



Scotch-Brite™ Brushes

Troubleshooting guide for stainless steel repair

Problem	Solution
Heat or warpage	<ul style="list-style-type: none"> <li>Use coarser grade abrasive</li> <li>Reduce speed</li> <li>Use new abrasive</li> <li>Use harder disc pad</li> </ul>
Edge cutting	<ul style="list-style-type: none"> <li>Use softer disc pad</li> <li>Reduce angle of grinder</li> </ul>
Disc scratches show through	<ul style="list-style-type: none"> <li>Use finer grade leveling disc</li> <li>Increase speed</li> </ul>
Chatter	<ul style="list-style-type: none"> <li>Reduce speed and/or pressure</li> </ul>
Flap wheel bounce	<ul style="list-style-type: none"> <li>Reduce speed and/or pressure</li> <li>Use smaller wheel</li> </ul>
Multi-finishing wheel bounce	<ul style="list-style-type: none"> <li>Reduce speed</li> <li>Dress wheel to round</li> </ul>
Smearing	<ul style="list-style-type: none"> <li>Reduce speed</li> <li>Clean or replace contaminated product</li> </ul>
Tool stalling	<ul style="list-style-type: none"> <li>Check for proper air supply at tool</li> <li>Increase torque and/or HP of tool</li> </ul>
Striking on final finish	<ul style="list-style-type: none"> <li>Use hand pad holder</li> </ul>

Description	UPC Number 051141-	Part Number	Dimensions	MOS RPM
Flap Brush 5A Extra Coarse	55748-9	55748	4 1/2" x 4" x 5/8 -11	3500
	55730-4	55730	4 1/2" x VARIABLE x 5/8 -11*	
High Strength Flap Brush 7A Coarse	55749-6	55749	4 1/2" x 4" x 5/8 -11	
	55731-1	55731	4 1/2" x VARIABLE x 5/8 -11*	
High Strength Flap Brush 7A Medium	55750-2	55750	4 1/2" x 4" x 5/8 -11	
	55732-8	55732	4 1/2" x VARIABLE x 5/8 -11*	
Flap Brush 5A Medium	55745-8	55745	4 1/2" x 4" x 5/8 -11	
	55727-4	55727	4 1/2" x VARIABLE x 5/8 -11*	
Flap Brush 5S Medium	55747-2	55747	4 1/2" x 4" x 5/8 -11	
	55729-8	55729	4 1/2" x VARIABLE x 5/8 -11*	
Flap Brush 5A Very Fine	55746-5	55746	4 1/2" x 4" x 5/8 -11	
	55728-1	55728	4 1/2" x VARIABLE x 5/8 -11*	
Combi Flap Brush A 60	55744-1	55744	4 1/2" x 4" x 5/8 -11	
	55726-7	55726	4 1/2" x VARIABLE x 5/8 -11*	
Combi Flap Brush A 100	55742-7	55742	4 1/2" x 4" x 5/8 -11	
	55724-3	55724	4 1/2" x VARIABLE x 5/8 -11*	
Combi Flap Brush A 150	55743-4	55743	4 1/2" x 4" x 5/8 -11	
	55725-0	55725	4 1/2" x VARIABLE x 5/8 -11*	

\* Also available in 4-way keyway attachments

Tools and Accessories

(See the 3M™ Power Tools, Abrasives and Accessories Catalog (61-5002-8217-5) for more tool options.

Description	UPC Number 051141-	Part Number	Dimensions	MOS RPM
3M™ Match & Finish Sander, 1 HP	28659-4	28659	4" x 5/8 -11 EXT	3500
3M™ Expander Wheels	28718-8	28718	5" x 3 1/2" x 1" Arbour Hole	
3M™ Expander Wheel Adapter Kit	28719-5	28719	1" x 5/8 -11 INT	
Alternate: 3M™ Inline Sander – 1 HP	28339-5	28339	5/8 -11 EXT Shaft	
Alternate: 3M™ Expander Wheel	28348-7	28348	5" x 3 1/2" x 5/8" Arbour Hole	
Alternate: 3M™ Wheel Adapter Kit #3	45038-1	45038	5/8 -11 INT x 5/8 -11 EXT	

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