



Belt Machines

		Equipment				Pressure			Application					Substrate						
		File Belt	Portable Tools	Backstand Grinders	Linishers	High	Medium	Low	Grinding	Deburring	Blending	Finishing	Coating Removal	Stainless Steel	Aluminium	Mild Steel	Cast Iron	Titanium	Nickle Alloy	Non-Ferrous
3M™ Belts																				
Best	3M™ Cubitron™ II Belt 984F	✓		✓		✓	✓		✓	✓	✓			✓		✓	✓	✓	✓	
Best	3M™ Cubitron™ II Belt 981F	✓	✓	✓	✓		✓	✓	✓		✓	✓			✓					✓
Best	3M™ Cubitron™ II Belt 947A	✓		✓			✓	✓	✓	✓	✓			✓		✓	✓	✓	✓	
Better	3M™ Cubitron™ II Belt 784F	✓		✓		✓	✓		✓	✓	✓			✓		✓	✓	✓	✓	
Best	3M™ Belt 237AA	✓	✓	✓	✓		✓	✓		✓		✓		✓		✓	✓		✓	
Scotch-Brite™ Belts																				
Best	Durable Flex	✓								✓	✓	✓		✓	✓	✓	✓	✓	✓	✓
Better	Surface Conditioning	✓	✓		✓					✓	✓		✓	✓	✓	✓	✓	✓	✓	✓

Grade Availability Chart

	P24	P36	P40	P50	P60	P80	P100	P120	P150	P180	P200	P220	P240	P280	P320	P360	P400	P500	P600	P800	P1000	P1200	P1500	P2000	P3000
984F		+			+	+		+																	
981F		+	+		+																				
947A			+		+	+		+																	
784F		+			+	+		+																	
237AA								A160			A100		A80		A60		A45		A30			A16			A6
Scotch-Brite™ Durable Flex									Coarse			Medium				Fine									
Scotch-Brite™ Surface Conditioning							SE Coarse		Coarse			Medium						Very Fine			Super Fine				

Belt Speed Recommendations

3M provides a broad range of products for your abrasive belt needs with each product offering a best-in-class performance! To help you get the most out of your 3M abrasive belts, we have provided the recommended speeds at which you should be running your belts.

Coated Belts, Speed Recommendations for Off-Hand Applications

(SFPM = Surface Feet Per Minute)

Alloy	Belt Speed (SFPM)	Application Belt Grades
Cast Iron	7,000	24 - 120
Mild Steel	6,500	24 - 120
Stainless Steel	6,500 - 7,000	36 - 120
Nickel Alloys	6,000	36 - 120
Titanium	2,500 - 3,000	36 - 180
Aluminium	7,500 - 8,500	24 - 120
	6,500 - 7,000	Finer Grades
Brass	7,000 - 8,000	36 - 180

Scotch-Brite™ Belt Applications Speed Recommendations

(SFPM = Surface Feet Per Minute)

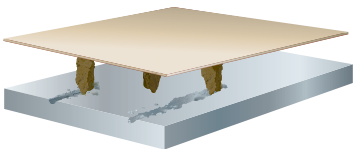
Application	Belt Speed (SFPM)
Decorative Finishing	500 - 3,000
Deburring	5,000 - 6,500
Cleaning & Conditioning	2,000 - 5,000
Oxide Removal	4,500 - 6,500

Maximum Operating Speed: 6,500 SFPM

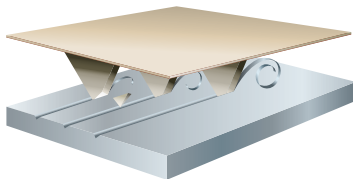
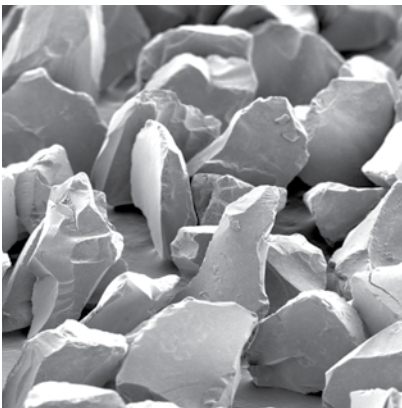
Shaping a new era of grinding performance.

For speed, long life and ease of use, nothing comes close to the power of 3M™ Cubitron™ II abrasives.

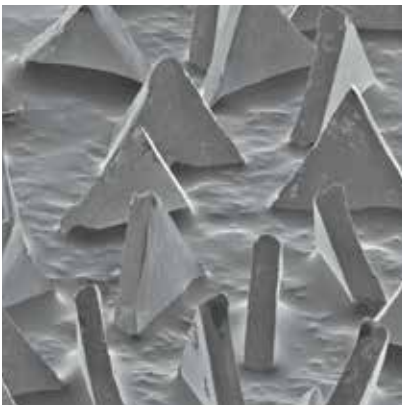
For grinding, weld blending, deburring and other tough metal finishing jobs, 3M™ Cubitron™ II Abrasives outperform other discs – thanks to a breakthrough 3M technology that re-writes the rules for speed and abrasive life. The secret lies in the revolutionary precision-shaped ceramic grain technology pioneered by 3M. As the triangular-shaped grain wears, it continuously fractures to form sharp points and edges that slice through metal, and provide a fast cut, long life and smooth-running feel.



Conventional ceramic abrasive grain is irregular and blocky in shape. Instead of a clean, machining action, the grain tends to “plow” through the metal, causing heat to build up in the workpiece and the abrasive – resulting in a slower cut, shorter belt life and undesirable effects, such as burnishing.



The new precision-shaped grain found in 3M™ Cubitron™ II Belts combines the advanced material properties of our original Cubitron 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 belt that cuts faster, stays cooler and lasts up to 4 times longer than the next best competitive belt.



3M™ Trizact™ Abrasives

Determined to provide the ultimate solution for precision finishing work, 3M™ Trizact™ abrasives allow you to say goodbye to erratic, inconsistent finishes generated by conventional coated abrasives.

The unique microreplicated construction of 3M™ Trizact™ Abrasives can deliver:

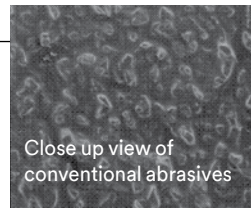
- Consistent, predictable finishes
- Higher, more even rates of cut
- Cooler finishing temperatures
- Reduced processing steps

How is 3M™ Trizact™ different?



Conventional abrasives start out sharp, but they dull quickly. These randomly arranged minerals, wear and finish unevenly.

3M™ Trizact™ Abrasives have three-dimensional structures containing multiple layers of abrasive mineral. As these pyramid-like structures wear, fresh, sharp mineral is exposed. This creates consistent performance and eliminates belt-to-belt variation.



Close up view of conventional abrasives



Close up view of 3M™ Trizact™ Abrasives

This technology is used in:

3M™ Trizact™ Cloth Belts 237AA

Ideal for fine metal finishing, including high precision and cosmetic or visual finishing. Suitable for stainless steel, mild steel, tool steels, cobalt, nickel alloys and titanium.



Scotch-Brite™ Surface Conditioning Products

The advantages of using genuine Scotch-Brite™ have been experienced by industries around the world for more than 50 years. 3M combines abrasive mineral with its non woven technology to create products that produce consistently uniform finishes to a work piece with minimal stock removal.

This three-dimensional, open structured material can deliver:

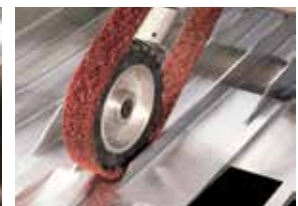
- Consistent, predictable finishes free from burrs
- Reduced risk of warping or discolouring because of lower heat generation
- Longer product life because of reduced loading
- Reduced risk of undercutting

Use Scotch-Brite™ Surface Conditioning Belts to achieve your desired finish on stainless steel

#3 Finish - A Coarse

#4 Finish - A Medium

#5 Finish - A Very Fine - S Super Fine



This technology is used in:

Scotch-Brite™ Surface Conditioning Belts & Discs

Used for a wide range of applications including decorative finishing, grindline conditioning, and blending on a variety of metals. The durable reinforced nylon and abrasive belts allow controlled cut to eliminate gouging, run cool and leave burr free finishes. Suitable for stainless steel, mild steel, tool steels, cobalt, nickel alloys and titanium.

Angle Grinders

Sanders

Hand Sanding

Belt Machines

Die Grinders

Fillet Weld Grinders

Bench Motors

3M Air Tools

3M Accessories

Tapes & Adhesives

Paint Finishing

Safety

Cloth Belts

3M™ Cubitron™ II Cloth Belt 984F

The 3M Cubitron II Cloth Belt 984F offers revolutionary performance with 3M Precision Shaped Grain on a YF-weight polyester cloth backing. This high-performing belt contains a grinding aid, making it ideal for medium to high pressure applications on stainless steel and other exotic alloys, along with mild steel, cobalt chrome and nickel alloys.

Size (mm)	Order QTY	36+	60+	80+	120+
10 × 330	30	AC010609280	AC010609298	AC010609306	AC010609314
12 × 330	25	AC019426926	AC019427643	AC019428161	AC010619362
19 × 457	15	AC010609405	AC010609413	AC010609421	AC010609439
20 × 520	15	AC010609447	AC010609454	AC010609462	AC010609470
30 × 533	10	AC010609520	AC010609538	AC010609546	AC010609553
50 × 915	6	AC010609561	AC010609579	AC010609587	AC010609595
50 × 1220	6	AC010609603	AC010609611	AC010609629	AC010609637
50 × 2440	6	AC010609686	AC010609694	AC010609702	AC010609710
50 × 4270	6	AC010609728	AC010609736	AC010609744	AC010609751
75 × 2000	4	AC010609769	AC010609777	AC010609785	AC010609793
100 × 915	3	AC010609843	AC010609850	AC010609868	AC010609876
100 × 1220	3	AC010609884	AC010609892	AC010609900	AC010609918
100 × 1520	3	AC010609926	AC010609934	AC010609942	AC010609959
100 × 2440	3	AC010610007	AC010610015	AC010610023	AC010610031
100 × 4270	3	AC010610049	AC010610056	AC010610064	AC010610072
150 × 1220	2	AC010610080	AC010610098	AC010610106	AC010610114
150 × 2000	2	AC010610122	AC010610130	AC010610148	AC010610155



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.

3M™ Cubitron™ II Cloth Belt 947A

Our 3M Cubitron II Abrasive Belt 947A, built with 3M Precision-Shaped Grain, cuts metal dramatically faster and cooler and stays sharp longer than conventional ceramic belts. Its X-weight poly-cotton backing is flexible. This belt is optimized for low and medium pressure applications on stainless steel, mild steel and aluminium.

Size (mm)	Order QTY	40+	60+	80+	120+
10 × 330	30	AC010610163	AC010610171	AC010610189	AC010610197
12 × 330	25	AC019427742	AC019427759	AC019427767	AC019427775
19 × 457	15	AC010610288	AC010610296	AC010610304	AC010610312
20 × 520	15	AC010610320	AC010610338	AC010610346	AC010610353
30 × 533	10	AC010610403	AC010610411	AC010610429	AC010610437
50 × 915	6	AC010610445	AC010610452	AC010610460	AC010610478
50 × 1220	6	AC010610486	AC010610494	AC010610502	AC010610510
50 × 2440	6	AC010610569	AC010610577	AC010610585	AC010610593
75 × 2000	4	AC010610643	AC010610650	AC010610668	AC010610676
100 × 915	3	AC010610726	AC010610734	AC010610742	AC010610759
100 × 1220	3	AC010610767	AC010610775	AC010610783	AC010610791
100 × 1520	3	AC010610809	AC010610817	AC010610825	AC019428278
100 × 2440	3	AC010610882	AC010610890	AC010610908	AC010610916
100 × 4270	3	AC010610924	AC010610932	AC010610940	AC010610957
150 × 1220	2	AC010610965	AC010610973	AC010610981	AC010610999
150 × 2000	2	AC010612110	AC010612128	AC010612136	AC010612482



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.

Cloth Belts

3M™ Cubitron™ II Cloth Belt 784F

3M Cubitron II Cloth Belt 784F features 3M Precision Shaped Grain for longer life and a faster, more consistent cut than aluminium oxide belts. A precise mix of shaped ceramic and premium aluminium oxide delivers optimal cut in medium pressure grinding and blending applications. The belt also features a waterproof backing and grinding aid.

Size (mm)	Order QTY	36+	60+	80+	120+
10 × 330	30	AC019428484	AC019428492	AC019428500	AC019428518
12 × 330	25	AC019428526	AC019428534	AC019428542	AC019428559
12 × 457	25	AC019428567	AC019428575	AC019428583	AC019428591
19 × 457	15	AC019428682	AC019428690	AC019428708	AC019428716
20 × 520	15	AC019428765	AC019428773	AC019428781	AC019428799
30 × 533	10	AC019429128	AC019429136	AC019429144	AC019429151
50 × 915	6	AC019429482	AC019429490	AC019429508	AC019429516
50 × 1220	6	AC019429607	AC019429615	AC019429623	AC019429631
50 × 2440	6	AC019429763	AC019429771	AC019429789	AC019429797
50 × 4270	6	AC019429847	AC019429854	AC019429862	AC019429870
75 × 2000	4	AC019430001	AC019430019	AC019430027	AC019430035
100 × 915	3	AC019430449	AC019430456	AC019430464	AC019430472
100 × 1220	3	AC019430522	AC019430530	AC019430548	AC019430555
100 × 1520	3	AC019430647	AC019430654	AC019430662	AC019430670
100 × 2440	3	AC019430761	AC019430779	AC019430787	AC019430795
100 × 4270	3	AC019430845	AC019430852	AC019430860	AC019430878
150 × 1220	2	AC019430969	AC019430977	AC019430985	AC019430993
150 × 2000	2	AC019431082	AC019431090	AC019431116	AC019431132



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.

3M™ Cubitron™ II Cloth Belt 981F

3M Cubitron II Cloth Belt 981F is an abrasive sanding belt for grinding, weld removal, finishing and blending on softer metals. It is constructed on a tough, Y-weight backing with fast-cutting 3M Precision-Shaped Grain.

The water-resistant material and cutting aide allow for use with liquid coolants to prevent loading when used on aluminium, bronze and brass.



All belts are converted locally, contact our Customer Service team for pricing on the belt size of your choice up to 300m in width.



Cloth Belts

3M™ Trizact™ 237AA Belts

3M Trizact Cloth 237AA is a good match for finishing and polishing on stainless steel, mild steel, high nickel alloys, titanium and aluminium and is designed to usher in those final touchups and refinements that come at the end of an abrasive sequence. We chose an X-weight cloth backing for 3M Trizact Cloth 237AA because of its strength and rigidity. This cloth stays tough when bent or rolled and won't tear or shell. It's desirable for workpieces that have already been shaped and prepped by grinding and deburring, because, at this stage in the process, parts often require an abrasive that won't yield or deflect when run. Aluminium oxide mineral cuts sharp but leaves a soft scratch pattern, ultimately producing a smooth, brushed finish. We offer 3M Trizact Cloth 237AA in a variety of grades, so operators can choose the right grade for their unique application.

Size (mm)	Order QTY	A160	A100	A65	A45
20 × 520	15	AC019411340	AC019411357	AC019411365	AC019411373
25 × 610	12	AC019411480	AC019411498	AC019411506	AC019411514
25 × 1680	12	AC019411415	AC019411423	AC019411431	AC019411449
30 × 533	10	AC019411621	AC019411639	AC019411647	AC019411654
30 × 600	10	AC019411761	AC019411779	AC019411787	AC019411795
40 × 760	7	AC019411902	AC019411910	AC019411928	AC019411936
50 × 315	6	AC019412116	AC019412124	AC019412132	AC019412140
50 × 914	6	AC019412256	AC019412264	AC019412272	AC019412280
50 × 1220	6	AC019411977	AC019411985	AC019411993	AC019412009
50 × 1520	6	AC019412041	AC019412058	AC019412066	AC019412074
90 × 400	3	AC019412322	AC019412330	AC019412348	AC019412355
100 × 285	3	AC019412397	AC019412405	AC019412413	AC019412421
100 × 315	3	AC019412462	AC019412470	AC019412488	AC019412496



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.

Surface Conditioning Belts

Scotch-Brite™ Surface Conditioning Belts - Scrim

The easiest way to a perfect finish. Choose Scotch-Brite Surface Conditioning Belts for cleaning, finishing, blending and deburring. The reinforced backing offers good flexibility whether working on a file belt or backstand. An ideal way to add a great finish or remove burrs without gouging or undercutting the work piece. Trust Scotch-Brite Belts to deliver fantastic finishes.

Size (mm)	Order QTY	A-CRS	A-MED	A-VFN	S-SFN
6 × 547	50	AC010620717	AC010620709	AC019437634	
10 × 330	30	AC019417933	AC019417925	AC019417917	AC010611070
12 × 457	25	AC010611088	AC010611096	AC010611104	
20 × 520	15	AC019417974	AC019417966	AC019417941	
30 × 610	10	AC010611161	AC010611179	AC010611187	
30 × 533	10	AC010611203	AC010611211	AC010611229	
40 × 760	7	AC019419525	AC019420044	AC019417396	AC019303885
50 × 915	6	AC010611245	AC010611252	AC010611260	AC010611278
50 × 1220	6	AC019410839	AC019420069	AC019410854	AC019410862
50 × 1520	6	AC019410870	AC019410888	AC019410896	
90 × 410	3	AC019413544	AC019418147	AC019422073	
100 × 915	3	AC019411076	AC019411084	AC019411092	
100 × 1520	3	AC019411159	AC019413874	AC019411175	



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.

Surface Conditioning Belts

Scotch-Brite™ Durable Flex Belts

Scotch-Brite Durable Flex Belts are engineered to perform tough detail work such as deburring, blending and finishing, on a variety of metals. The reinforced, low-stretch backing and superior edge durability aid in supplying an aggressive cutting ability. The non-woven fibre material runs cool, resists loading and holds up to edge work while aluminium oxide abrasives provide effective cutting action that produces consistent finishing performance over the life of the belt. Aluminium oxide is a popular choice among industrial professionals because of its cut-rate and long life. This mineral is a tough, durable abrasive that self-fractures to expose fresh cutting edges in use, whereas traditional abrasives, such as garnet, quickly wear down with use. Due to its high cut-rate, hardness, strength, and low heat retention, aluminium oxide mineral is widely used in grinding applications in addition to sanding and finishing use. Aluminium oxide is suitable on a wide variety of substrates in both woodworking and metalworking, including ferrous alloys.

Size (mm)	Order QTY	A-CRS	A-MED	A-FIN
6 × 457	20	61500295961	61500295805	61500295888
10 × 330	20	AC010593344	AC010593351	AC010593369
12 × 457	20	61500295995	61500295839	61500295912
20 × 520	20	AC010593435	AC010593443	AC010593450
25 × 610	10	AC010593468	AC010593476	AC010593484
50 × 914	10	AC019309445	AC019309452	AC019309460
101 × 295	10	AC019311003	AC019311011	AC019311029



All belts will be converted locally to any width up to 300mm. For additional sizes please contact 3M Customer Service.



Angle
Grinders

Sanders

Hand
Sanding

Belt
Machines

Die
Grinders

Fillet Weld
Grinders

Bench
Motors

3M
Air Tools

3M
Accessories

Tapes &
Adhesives

Paint
Finishing

Safety