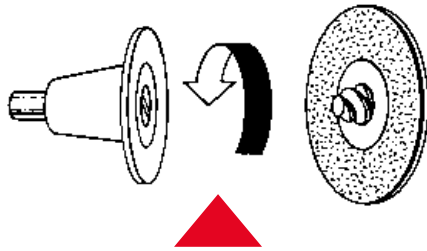


# What is Roloc™?

## The benefits of the Roloc™ attachment

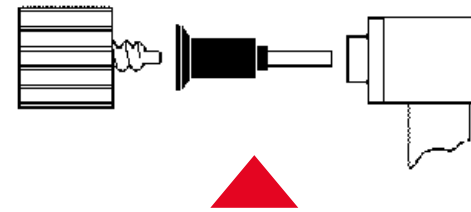
3M™ Roloc™ Abrasive Discs are smaller discs that quickly attach onto a Roloc™ disc pad so that you can conveniently and rapidly change discs as needed. Our system provides a secure attachment even for heavy-duty applications. Each disc is also color-coded to identify its grade, making it easy to select the grade required for different applications.

- ▶ Remote applications
- ▶ Retain extra control
- ▶ Localized, refining, finishing
- ▶ Corner or curved surfaces
- ▶ Intricate, difficult to reach areas
- ▶ Remove weld splatter on small areas



### 3M™ Roloc™ Quick Release System

- ▶ 3M™ Roloc™ discs are designed for use on the face of the disc
- ▶ Available in a range of products for grinding, finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ Back-Up Pad assures secure fixing with rapid grade or product change
- ▶ Can be used with 3M™ Roloc™ Rubber Back-Up Pad




### 3M™ Roloc™+ Quick Release System

- ▶ 3M™ Roloc™+ discs/brushes are designed for use on the edge and have a longer shaft for extra strength
- ▶ Available in a range of products for finishing, deburring and cleaning applications
- ▶ The 3M™ Roloc™ plastic holder assures secure fixing with rapid grade or product change
- ▶ To be used with all 3M™ Roloc™+ plastic holders (excluding 3M™ Roloc™ rubber back-up pads)

### 3M™ Roloc™ Disc button color/grade chart


|   |                   |
|---|-------------------|
| ● | 24+ grade/black   |
| ● | 36+ grade/brown   |
| ● | 50+ grade/green   |
| ● | 60+ grade/orange  |
| ● | 80+ grade/yellow  |
| ● | P100 grade/blue   |
| ○ | P120 grade/white  |
| ● | P150 grade/black  |
| ● | P180 grade/brown  |
| ● | P240 grade/green  |
| ● | P320 grade/yellow |
| ● | P400 grade/blue   |

### 3M™ Roloc™ Attachment System Guide




**TR** – plastic button

| Diameter | Attachment type |     |    |
|----------|-----------------|-----|----|
|          | TR              | TSM | TS |
| 3/4"     | ◆               |     | ◆  |
| 1"       | ◆               | ◆   | ◆  |
| 1-1/2"   | ◆               | ◆   | ◆  |
| 2"       | ◆               | ◆   | ◆  |
| 3"       | ◆               | ◆   | ◆  |
| 4"       | ◆               |     | ◆  |



**TSM** – metal button

| Product ID | Attachment type |     |    |
|------------|-----------------|-----|----|
|            | TR              | TSM | TS |
| 361F       | ◆               | ◆   |    |
| 777F       | ◆               | ◆   | ◆  |
| 947A       | ◆               | ◆   |    |
| 984F       | ◆               | ◆   |    |
| 782C       | ◆               | ◆   |    |
| 787C       | ◆               | ◆   |    |
| 982C       | ◆               | ◆   |    |
| 987C       | ◆               | ◆   |    |



**TS** – plastic button

### Optimum tool speeds to maximize 3M™ Roloc™ Disc cut rates and life

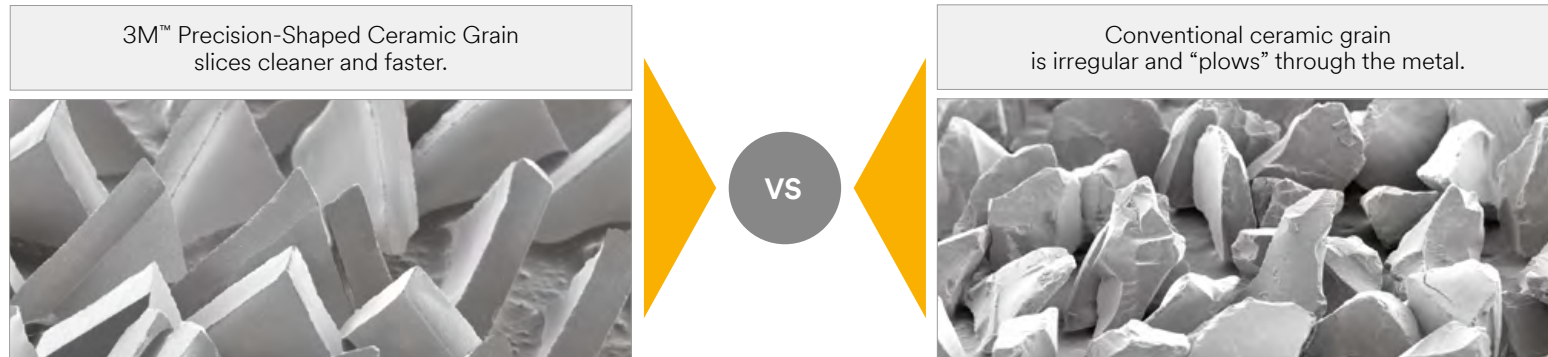
| Disc size | Material   |            |            |           |
|-----------|------------|------------|------------|-----------|
|           | Stainless  | Aluminum   | Steel      | Titanium  |
| 1-1/2"    | 20,000 RPM | 30,000 RPM | 30,000 RPM | 9,000 RPM |
| 2"        | 15,000 RPM | 20,000 RPM | 20,000 RPM | 7,000 RPM |
| 3"        | 10,000 RPM | 15,000 RPM | 15,000 RPM | 4,500 RPM |
| 4"        | 8,000 RPM  | 9,000 RPM  | 9,000 RPM  | 3,000 RPM |

## Technology:

# CUBITRON™ II

3M™ Cubitron™ II Abrasives are revolutionizing the cutting and grinding process. They're faster-cutting and longer-lasting than conventional abrasives.

The secret lies in the revolutionary 3M™ Precision-Shaped Ceramic Grain technology. As the triangular-shaped grain wears, it continuously fractures to form sharp peaks that slice through metal – providing a cooler, faster and longer lasting cut.



- ✓ Cooler operation
- ✓ Clean cut
- ✓ Lasts much longer



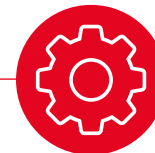
- ✗ Heat build-up
- ✗ Slower cutting
- ✗ Shorter life



Cuts faster



Works harder



Increases productivity

# Application guide



















Application use:

## Premium Series

Designed for unparalleled power and performance





### Color key for navigating product sections:

-  = Grinding and stock removal
-  = Deburring
-  = Refining and finishing
-  = Contamination removal and cleaning
-  = Roloc+ range

| Products:   | Page # | Substrate use:   | Grinding & stock removal | Deburring      | Refining | Finishing | Cleaning | Contaminate removal |
|---|--------|--|--------------------------|----------------|----------|-----------|----------|---------------------|
|  3M™ Cubitron™ II Roloc™ Disc 984F                                   | 13     | mild steel, stainless steel                            | heavy                    | ◆              | ◆        | ◆         |          |                     |
|  3M™ Cubitron™ II Roloc™ Disc 947A                                   | 14     | mild steel, stainless steel, aluminum                  | medium                   |                |          | ◆         |          |                     |
|  3M™ Cubitron™ II Roloc™ Fibre Disc 982C                             | 15     | mild steel   | medium/high              | ◆              | ◆        |           |          |                     |
|  3M™ Cubitron™ II Roloc™ Fibre Disc 987C                             | 16     | stainless steel, non-ferrous metals, aluminum          | medium/high              | ◆              | ◆        |           |          |                     |
|  Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)     | 25     | all metals   |                          | heavy          |          | ◆         |          |                     |
|  Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)                     | 26     | metals, plastics, composites                           |                          | moderate/heavy |          | ◆         |          |                     |
|  Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)               | 27     | all metals   |                          | edge           |          | ◆         |          |                     |
|  Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR) | 30-31  | aluminum, white metals                                 |                          |                |          | ◆         |          |                     |
|  Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)              | 32-33  | all metals   |                          | ◆              | ◆        | ◆         | ◆        |                     |
|  Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)             | 34     | all metals   |                          | light          |          | ◆         |          |                     |
|  Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)              | 35     | all metals   |                          | heavy          | ◆        | ◆         | ◆        |                     |
|  Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)              | 38     | rust, coatings, weld discoloration                     |                          |                |          |           | ◆        | heavy removal       |
|  Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)    | 39     | heavy rust and rust pit removal without leaving divots |                          |                | ◆        |           | ◆        | ◆                   |
|  Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)                           | 40     | all metals   |                          | ◆              |          | ◆         | ◆        |                     |
|  Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)                | 42     | wood, metals, lacquers                                 |                          | light          |          |           | ◆        |                     |
|  Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)                  | 42     | all metals   |                          | light          |          | ◆         | ◆        |                     |
|  Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc         | 43     | corrosion, coatings, metals                            |                          |                | ◆        |           | ◆        | ◆                   |
|  Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc                   | 43     | corrosion, coatings, metals                            |                          |                |          |           | ◆        | heavy removal       |

## Advanced Series

Designed for value-priced performance

| Products:  | Page # | Substrate use:  | Grinding & stock removal | Deburring | Refining | Finishing | Cleaning | Contaminate removal |
|--|--------|---|--------------------------|-----------|----------|-----------|----------|---------------------|
|  3M™ Roloc™ Fibre Disc 782C | 17     | mild steel  | medium/high              | ◆         | ◆        | ◆         |          |                     |
|  3M™ Roloc™ Fibre Disc 787C | 18     | stainless steel, non-ferrous metals, aluminum             | medium/high              | ◆         | ◆        | ◆         |          |                     |
|  3M™ Roloc™ Disc 777F       | 19-20  | mild steel, stainless steel, non-ferrous metals, aluminum | medium                   |           |          | ◆         |          |                     |
|  3M™ Roloc™ Disc 361F       | 21-22  | all metals  |                          |           | ◆        | ◆         | ◆        | ◆                   |

# Application guide continued from previous page >>>

## Application use:

### Premium Series

#### Products:

#### Page #

#### Substrate use:

#### Beveling

#### Weld prep

#### Weld removal

#### Blending





#### Rust removal

#### Paint prep

|   |   |       |  |   |   |             |               |   |   |
|---|---|-------|--|---|---|-------------|---------------|---|---|
|    | 3M™ Cubitron™ II Roloc™ Disc 984F                                   | 13    | mild steel, stainless steel                            | ◆ | ◆ | small welds | ◆             |   |   |
|    | 3M™ Cubitron™ II Roloc™ Disc 947A                                   | 14    | mild steel, stainless steel, aluminum                  |   |   |             |               |   |   |
|    | 3M™ Cubitron™ II Roloc™ Fibre Disc 982C                             | 15    | mild steel   |   |   | small welds | ◆             |   |   |
|    | 3M™ Cubitron™ II Roloc™ Fibre Disc 987C                             | 16    | stainless steel, non-ferrous metals, aluminum          |   |   | small welds | ◆             |   |   |
|    | Scotch-Brite™ Roloc™ Deburr & Finish Pro Unitized Wheel (DP-UW)     | 25    | all metals   |   |   |             | ◆             |   |   |
|    | Scotch-Brite™ Roloc™ EXL Unitized Wheel (DP-UR)                     | 26    | metals, plastics, composites                           |   |   |             | weld blending |   |   |
|    | Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheel (RC-UR)               | 27    | all metals   |   |   |             | weld blending |   |   |
|    | Scotch-Brite™ Roloc™ Anti-loading Surface Conditioning Disc (AL-DR) | 30-31 | aluminum, white metals                                 |   |   |             | ◆             |   |   |
|    | Scotch-Brite™ Roloc™ Surface Conditioning Disc (SC-DR)              | 32-33 | all metals   |   |   |             | ◆             |   | ◆ |
|    | Scotch-Brite™ Roloc™ Light Grind and Blend Disc (GB-DR)             | 34    | all metals   |   |   | small welds | ◆             |   | ◆ |
|    | Scotch-Brite™ Roloc™ Surface Conditioning Disc (SE-DR)              | 35    | all metals   |   |   |             |               |   |   |
|    | Scotch-Brite™ Roloc™ Clean & Strip XT Pro Disc (XO-DR)              | 38    | rust, coatings, weld discoloration                     |   |   |             |               | ◆ | ◆ |
|    | Scotch-Brite™ Roloc™ Clean & Strip XT Pro Extra Cut Disc (XC-DR)    | 39    | heavy rust and rust pit removal without leaving divots |   |   |             |               | ◆ | ◆ |
|    | Scotch-Brite™ Roloc™ Bristle Disc (RD-ZB)                           | 40    | all metals   |   |   |             | ◆             | ◆ |   |
|   | Scotch-Brite™ Roloc+™ Flap Brush (FF-ZR/PF-ZR/CB-ZR)                | 42    | wood, metals, lacquers                                 |   |   |             |               |   |   |
|  | Scotch-Brite™ Roloc+™ Cut and Polish Disc (C5/ZR)                   | 42    | all metals   |   |   |             |               |   |   |
|  | Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Extra Cut Disc           | 43    | corrosion, coatings, metals                            |   |   |             |               |   |   |
|  | Scotch-Brite™ Roloc+™ Clean & Strip XT Pro Disc                     | 43    | corrosion, coatings, metals                            |   |   |             |               |   |   |

### Advanced Series

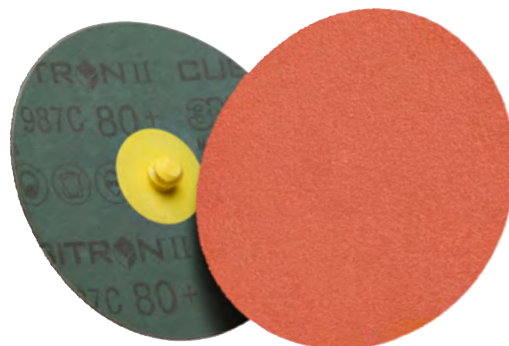
#### Products:

|   |                            |       |   |  |  |             |   |   |  |
|---|----------------------------|-------|---|--|--|-------------|---|---|--|
|  | 3M™ Roloc™ Fibre Disc 782C | 17    | mild steel  |  |  | small welds | ◆ |   |  |
|  | 3M™ Roloc™ Fibre Disc 787C | 18    | stainless steel, non-ferrous metals, aluminum             |  |  | small welds | ◆ |   |  |
|  | 3M™ Roloc™ Disc 777F       | 19-20 | mild steel, stainless steel, non-ferrous metals, aluminum |  |  |             | ◆ |   |  |
|  | 3M™ Roloc™ Disc 361F       | 21-22 | all metals  |  |  |             |   | ◆ |  |

# 3M™ Cubitron™ II Roloc™ Disc 987C

## Premium Series

for unparalleled power and performance





**Feature:**  
3M™ Precision-Shaped Ceramic Grain, grinding aid

**Backing:**  
Rigid fibre backing

**Application:**  
Weld prep, weld removal

**Substrate:**  
Stainless steel and other heat-sensitive alloys

| UPC  | Diameter (inches) | Grade | Button color | Max. speed (RPM) | Min./case |
|--|-------------------|-------|--------------|------------------|-----------|
| <b>Roloc™ TR (plastic button)</b>   |                   |       |              |                  |           |
| 051125-94952-1   | 2"                | 36+   | Brown        | 25,000           | 50/200    |
| 051125-94957-6   | 2"                | 60+   | Orange       | 25,000           | 50/200    |
| 051125-94962-0   | 2"                | 80+   | Yellow       | 25,000           | 50/200    |
| 051125-94953-8   | 3"                | 36+   | Brown        | 20,000           | 50/200    |
| 051125-94958-3   | 3"                | 60+   | Orange       | 20,000           | 50/200    |
| 051125-94963-7   | 3"                | 80+   | Yellow       | 20,000           | 50/200    |
| 051125-94954-5   | 4"                | 36+   | Brown        | 12,000           | 25/100    |
| 051125-94959-0   | 4"                | 60+   | Orange       | 12,000           | 25/100    |
| 051125-94964-4   | 4"                | 80+   | Yellow       | 12,000           | 25/100    |
| <b>Roloc™ TSM (metal button)</b>  |                   |       |              |                  |           |
| 051125-94955-2   | 2"                | 36+   | Metal        | 25,000           | 50/200    |
| 051125-94960-6   | 2"                | 60+   | Metal        | 25,000           | 50/200    |
| 051125-94965-1   | 2"                | 80+   | Metal        | 25,000           | 50/200    |
| 051125-94956-9   | 3"                | 36+   | Metal        | 20,000           | 50/200    |
| 051125-94961-3   | 3"                | 60+   | Metal        | 20,000           | 50/200    |
| 051125-94966-8   | 3"                | 80+   | Metal        | 20,000           | 50/200    |

- ▶ Best-in-class for weld prep and removal, 3M™ Cubitron™ II Roloc™ Fibre Disc 987C features 3M precision-shaped grain technology for an ultra-rapid cut
- ▶ 3M precision-shaped ceramic grain has ultra-sharp, fast-cutting points that wear evenly, run cool and optimize mineral breakdown to maximize life
- ▶ Excellent choice for weld removal, blending and finish refinement on stainless steel and high nickel alloys