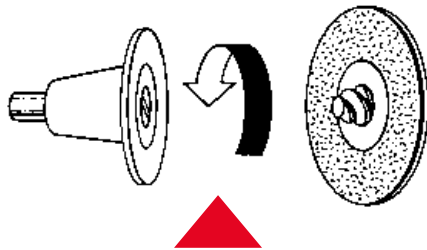


What is Roloc™?

The benefits of the Roloc™ attachment

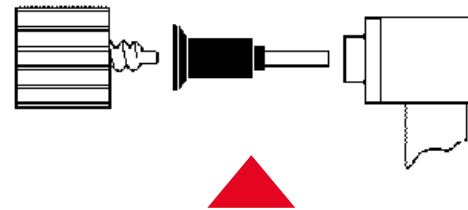
3M™ Roloc™ Abrasive Discs are smaller discs that quickly attach onto a Roloc™ disc pad so that you can conveniently and rapidly change discs as needed. Our system provides a secure attachment even for heavy-duty applications. Each disc is also color-coded to identify its grade, making it easy to select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

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

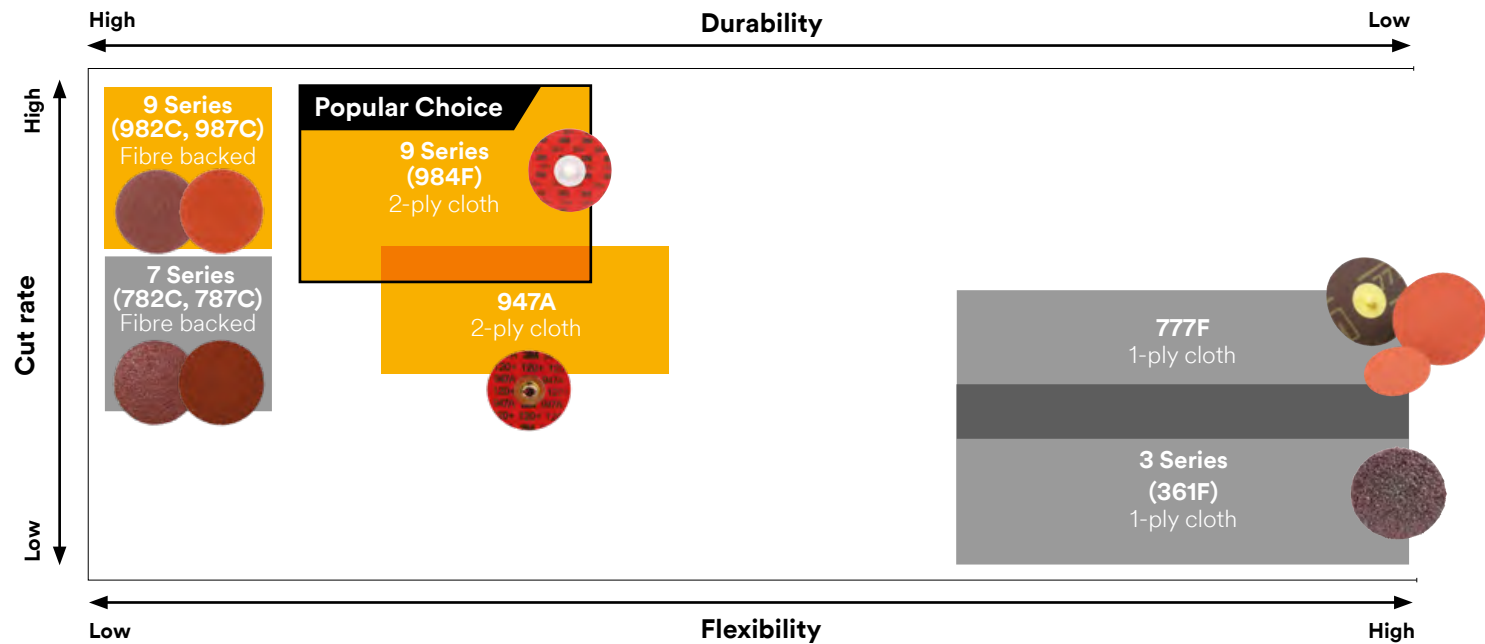
	3M™ Cubitron™ II Roloc™ Disc 984F	13	mild steel, stainless steel	◆	◆	small welds	◆		
	3M™ Cubitron™ II Roloc™ Disc 947A	14	mild steel, stainless steel, aluminum						
	3M™ Cubitron™ II Roloc™ Fibre Disc 982C	15	mild steel			small welds	◆		
	3M™ Cubitron™ II Roloc™ Fibre Disc 987C	16	stainless steel, 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					◆	

Positioning | Grinding and stock removal



Please note: Back-up pad affects disc performance


Premium Series Products:	Feature	Substrate	Application
3M™ Cubitron™ II Roloc™ Fibre Disc 982C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, refining, deburring, small beveling
3M™ Cubitron™ II Roloc™ Fibre Disc 987C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Cubitron™ II Roloc™ Durable Edge Disc 984F	3M™ Precision-Shaped Ceramic Grain, durable edge, grinding aid	Mild steel, stainless steel	Beveling, weld prep, small weld removal, blending, finishing, refining, deburring
3M™ Cubitron™ II Roloc™ Durable Edge Disc 947A	3M™ Precision-Shaped Ceramic Grain blend, durable edge, grinding aid	Mild steel, stainless steel, aluminum	Works for lighter applications than 984F due to the blend of 3M™ Precision-Shaped Ceramic Grain and conventional grain
Advanced Series Products:			
3M™ Roloc™ Fibre Disc 782C	3M™ Precision-Shaped Ceramic Grain	Mild steel	Small weld removal, blending, finishing, refining, deburring, small beveling
3M™ Roloc™ Fibre Disc 787C	3M™ Precision-Shaped Ceramic Grain, grinding aid	Stainless steel, non-ferrous metals, aluminum	
3M™ Roloc™ Disc 777F	Ceramic and aluminum oxide blend, grinding aid	Mild steel, stainless steel, non-ferrous metals, aluminum	Medium stock removal, grinding, blending
3M™ Roloc™ Disc 361F	Aluminum oxide, good grade range	All metals	General purpose applications, rust removal, cleaning, contaminate removal, finishing, refining

3M™ Roloc™ Disc 777F

Advanced Series

for value-priced performance



UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TR (plastic button) 					
051144-76622-2	1"	36	Brown	30,000	50/500
051144-76623-9	1"	50	Green	30,000	50/500
051144-76624-6	1"	60	Orange	30,000	50/500
051144-76625-3	1"	80	Yellow	30,000	50/500
638060-70794-4	1"	P100	Blue	30,000	50/500
051144-80510-5	1"	P120	White	30,000	50/500
051119-57828-7	1"	P150	Black	30,000	50/500
051119-40434-0	1"	P180	Brown	30,000	50/500
051144-76627-7	1-1/2"	50	Green	30,000	50/500
051144-76628-4	1-1/2"	60	Orange	30,000	50/500
051144-14660-4	1-1/2"	80	Yellow	30,000	50/500
051144-80511-2	1-1/2"	P120	White	30,000	50/500
051144-76629-1	2"	36	Brown	25,000	50/200
051144-76630-7	2"	50	Green	25,000	50/200
051144-76433-4	2"	60	Orange	25,000	50/200
051144-14661-1	2"	80	Yellow	25,000	50/200
051144-80508-2	2"	P100	Blue	25,000	50/200
051144-80512-9	2"	P120	White	25,000	50/200
051144-83469-3	2"	P150	Black	25,000	50/200
051144-76631-4	3"	36	Brown	20,000	50/200
051144-76632-1	3"	50	Green	20,000	50/200
051144-76633-8	3"	60	Orange	20,000	50/200
051144-76634-5	3"	80	Yellow	20,000	50/200
051144-80509-9	3"	P100	Blue	20,000	50/200
051144-80513-6	3"	P120	White	20,000	50/200
051119-16295-0	3"	P150	Black	20,000	50/200
051125-40045-9	3"	P180	Brown	20,000	50/200

Feature:
Ceramic and aluminum oxide blend, grinding aid

Backing:
Y weight polyester cloth

Application:
Medium stock removal, medium pressure

Substrate:
Mild steel, stainless steel, non-ferrous metals, aluminum

- ▶ 3M™ Roloc™ Disc 777F ensures a fast and consistent cut rate for all types of medium-pressure grinding and blending applications
- ▶ Grinding aid reduces grinding temperatures for processes involving heat-sensitive alloys such as stainless steel, nickel alloys and titanium

CHART CONTINUES (on next page)

< PREVIOUS | NEXT >

[Return to TOC](#)



3M™ Roloc™ Disc 777F

Advanced Series

for value-priced performance



CHART CONTINUED (from previous page)

UPC	Diameter (inches)	Grade	Button color	Max. speed (RPM)	Min./case
Roloc™ TSM (metal button) 					
051111-49949-8	2"	36	Metal	25,000	50/200
051111-50253-2	2"	60	Metal	25,000	50/200
051111-50254-9	2"	80	Metal	25,000	50/200
051111-50255-6	2"	P100	Metal	25,000	50/200
051111-50256-3	2"	P120	Metal	25,000	50/200
051119-19462-3	2"	P180	Metal	25,000	50/200
051111-50257-0	3"	36	Metal	20,000	50/200
051111-50257-0	3"	60	Metal	30,000	50/500
051111-50257-0	3"	80	Metal	30,000	50/2500
051111-50257-0	3"	P120	Metal	25,000	50/200
Roloc™ TS (plastic button) 					
051144-76742-7	2"	36	Brown	25,000	50/200
051144-76746-5	2"	50	Green	25,000	50/200
051144-76750-2	2"	60	Orange	25,000	50/200
051144-76754-0	2"	80	Yellow	25,000	50/200
051119-84478-8	2"	P100	Blue	25,000	50/500
051125-19363-4	2"	P120	White	25,000	50/500
051144-76743-4	3"	36	Brown	20,000	50/200
051144-76747-2	3"	50	Green	20,000	50/200
051144-76751-9	3"	60	Orange	20,000	50/200
051144-76755-7	3"	80	Yellow	20,000	50/200
051125-39547-2	3"	P100	Blue	20,000	50/200
051125-21811-5	3"	P120	White	20,000	50/200