

# Abrasive Belt Systems

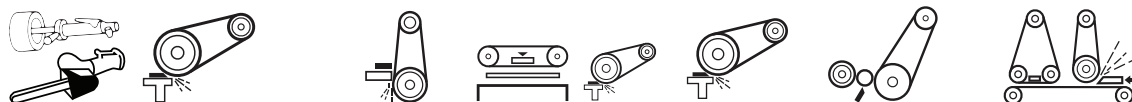
## 3M™ Belts

3M is the one-stop shop for all your coated abrasive metalworking belt needs! We offer a product tailored to nearly every application and performance level. To select the best product for your application, check out our easy-to-use Belt Selection Guide. Each tier of product offers best-in-class performance at various price points. Once you have selected the product, use the Availability Guide to select your grade. The following section includes our most popular belt items, but remember, other custom sizes are available.

### How to Use the Coated Abrasive Belt Selection Guide

1. Find the machine type that you will run this belt on.
2. Move down to the metal type that is being worked on.
3. Select the product from the list of Recommended — Alternative — Finishing/Polishing belts.\*
4. Check the Availability Guide for the grade.
5. Find the product on the following pages for available sizes.
6. If your size is not listed, contact your 3M distributor or 3M representative for ordering instructions.

### 3M™ Coated Abrasive Belt Selection Guide



| Recommended Starting Point               | Portable File Belt | Coarse Grade High Pressure Grinding | Backstand/Off Hand Low-Med Pressure | Stroke Sander | Bench Top Belt Sander | Slack of Belt Sander | Centerless and Roll Grinding |       | Flat and Wide Belt Finishing |       |
|--|--------------------|-------------------------------------|-------------------------------------|---------------|-----------------------|----------------------|------------------------------|-------|------------------------------|-------|
|  |                    |                                     |                                     |               |                       |                      | Dry                          | Wet   | Dry                          | Wet   |
| <b>Carbon Steel and Cast Iron</b>        |                    |                                     |                                     |               |                       |                      |                              |       |                              |       |
| <b>Recommended</b>                       | 784F               | 984F                                | 784F                                | 384F          | 784F                  | 947A                 | 784F                         | 984F  | 784F                         | 784F  |
| <b>Alternative</b>                       | 947A               | 994F                                | 984F                                | 784F          | 947A                  | 723D                 | 384F                         | 784F  | 577F                         | 577F  |
| <b>Finishing/Polishing</b>               | 384F               | —                                   | 947A                                | 947A          | 384F                  | 784F                 | 347FC                        | 363FC | 384F                         | 384F  |
|  | —                  | —                                   | —                                   | —             | —                     | —                    | 399F                         | 399F  | 399F                         | 399F  |
| <b>Stainless Steel and Cobalt Chrome</b> |                    |                                     |                                     |               |                       |                      |                              |       |                              |       |
| <b>Recommended</b>                       | 784F               | 984F                                | 784F                                | 784F          | 784F                  | 947A                 | 784F                         | 984F  | 784F                         | 784F  |
| <b>Alternative</b>                       | 947A               | 997F                                | 984F                                | 947A          | 947A                  | 784F                 | 384F                         | 784F  | 577F                         | 577F  |
| <b>Finishing/Polishing</b>               | 384F               | —                                   | 947A                                | 384F          | 384F                  | —                    | 347FC                        | 363FC | 461F                         | 461F  |
|  | —                  | —                                   | —                                   | —             | —                     | —                    | 399F                         | 399F  | 399F                         | 399F  |
| <b>Aluminum and Soft Substrates</b>      |                    |                                     |                                     |               |                       |                      |                              |       |                              |       |
| <b>Recommended</b>                       | 981F               | 984F                                | 981F                                | 981F          | 981F                  | 947A                 | 784F                         | 784F  | 384F                         | 384F  |
| <b>Alternative</b>                       | 784F               | 784F                                | 784F                                | 784F          | 784F                  | 784F                 | 384F                         | 384F  | 361F                         | 361F  |
| <b>Finishing/Polishing</b>               | 384F               | —                                   | 384F                                | 384F          | 384F                  | 384F                 | 237AA                        | 253FA | 461F                         | 461F  |
| <b>Titanium</b>                          |                    |                                     |                                     |               |                       |                      |                              |       |                              |       |
| <b>Recommended</b>                       | 967F               | 967F                                | 967F                                | —             | 967F                  | 947A                 | N/A                          | 966F  | N/A                          | 966F  |
| <b>Alternative</b>                       | 784F               | 984F                                | 784F                                | —             | 784F                  | 784F                 | N/A                          | 784F  | N/A                          | 461F  |
| <b>Finishing/Polishing</b>               | 947A               | —                                   | 461F                                | —             | 947A                  | —                    | N/A                          | —     | N/A                          | —     |
|  | —                  | —                                   | —                                   | —             | —                     | —                    | N/A                          | 463FC | N/A                          | 463FC |

\*Recommended is the potential best starting point based on the application. Alternative is another option based either on a different flexibility and durability need, or a possible lower initial belt cost. Value shown in belt process can be viewed as an increase in throughput, lower overall belt cost, and faster sanding or grinding time.



## 3M™ Trizact™ Cloth Belts

### 407EA

- Use for mill line removal, intermediate scratch refinement, consistent dimensioning and consistent finishing applications
- Silicon carbide constructed on a flexible rayon cloth backing
- Grinding aid for cooler grinding
- Resin bonded for heat resistance



| UPC            | W x L  | Grade | Qty/Case                |
|----------------|--|-------|-------------------------|
| 051125-71792-2 | Belt sizes made to order; specify UPC, grade and belt size (W" x L") | A20   | Determined by belt size |
| 051125-71793-9 |  | A60   |                         |
| 051125-71794-6 |  | A90   |                         |
| 051125-71795-3 |  | A110  |                         |

### 953FA

- Use in wet centerless or flat grinding and finishing operations
- Process flexible belt that delivers consistent, predictable results
- Macroreplicated ceramic abrasive grain coated on waterproof cloth backing



| UPC            | W x L   | Grade | Qty/Case                |
|----------------|---|-------|-------------------------|
| 051125-71978-0 | Belt sizes made to order; specify UPC, grade and belt size (W" x L"); belts wider than 25" require multiple splices | A6    | Determined by belt size |
| 051125-71989-6 |   | A10   |                         |
| 051125-71979-7 |   | A16   |                         |
| 051125-71980-3 |   | A30   |                         |
| 051125-71981-0 |   | A45   |                         |
| 051125-71982-7 |   | A65   |                         |
| 051125-71983-4 |   | A80   |                         |
| 051125-71984-1 |   | A100  |                         |
| 051125-71986-5 |   | A160  |                         |
| 051125-71988-9 |   | A300  |                         |

## 3M™ Belts

### 384F

- Workhorse for general purpose metalworking applications
- Consistent performance on all metals at a great value
- Waterproof X wt polyester backing
- Available in grades 36+ to 240+; P320-400



| UPC             | Size         | Grade | Qty/Case                |
|-----------------|--------------|-------|-------------------------|
| 076308-47073-9  | 1/2" x 18"   | 36+   | 200                     |
| 076308-45587-3  |              | 60+   |                         |
| 076308-45588-0  |              | 80+   |                         |
| 076308-45586-6† |              | 120+  |                         |
| 076308-47069-2  | 1/2" x 24"   | 36+   | 200                     |
| 076308-47070-8  |              | 60+   |                         |
| 076308-47071-5  |              | 80+   |                         |
| 051125-87318-5  |              | 120+  |                         |
| 076308-47072-2  | 3/4" x 18"   | 36+   | 200                     |
| 076308-45583-5  |              | 60+   |                         |
| 076308-45584-2  |              | 80+   |                         |
| 076308-45585-9† |              | 120+  |                         |
| 076308-45579-8† | 1" x 42"     | 80+   | 200                     |
| 076308-45580-4  |              | 120+  |                         |
| 076308-45575-0  | 2" x 60"     | 60+   | 50                      |
| 076308-45574-3† |              | 80+   |                         |
| 076308-45581-1  | 6" x 48"     | 60+   | 20                      |
| 076308-45582-8  |              | 80+   |                         |
| 076308-45573-6† | 6" x 264"    | 80+   | 20                      |
| 076308-45577-4  | 37" x 60"    | 80+   | 5                       |
| 076308-45576-7  |              | 120+  |                         |
| 076308-47067-8† |              | 150+  |                         |
| 076308-47065-4† |              | 180+  |                         |
| 076308-45578-1† | 37" x 75"    | 120+  | 5                       |
| 076308-47059-3† | 2" x 132"    | 36+   | 50                      |
| 076308-47060-9  |              | 60+   |                         |
| 076308-47061-6† | 3" x 132"    | 36+   | 50                      |
| 076308-47063-0  |              | 60+   |                         |
| 076308-47064-7† |              | 80+   |                         |
| 076308-68116-6* | Custom sizes | 36+   | Determined by belt size |
| 076308-68118-0* |              | 50+   |                         |
| 076308-68119-7* |              | 60+   |                         |
| 076308-68120-3* |              | 80+   |                         |
| 076308-68122-7* |              | 120+  |                         |
| 076308-68123-4* |              | 150+  |                         |
| 076308-68124-1* |              | 180+  |                         |
| 076308-68236-1* |              | 220+  |                         |
| 076308-68125-8* |              | 240+  |                         |
| 076308-68126-5* |              | P320  |                         |
| 076308-68127-2* |              | P400  |                         |

Available in grades 36+ to 400+  
 \*3M ID — Custom size made to order