











▶ Film/Paper Backed
Cloth Backed/Non-woven

Random Orbital Sanding Portfolio *The entire 3M portfolio*

Film backed sanding discs

Best for a uniform consistent finish. Have good tear resistance and durability. Longer life than paper.

 <p>255L</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on 2 mil film ▶ Lightweight film disc suited for prep for paint, buff and wood sanding applications 	 <p>568XA* <small>Specialized Applications</small></p> <ul style="list-style-type: none"> ▶ Cerium Oxide on 3 mil film ▶ Constructed for high gloss, semi gloss and acrylic solid surface applications 	 <p>268L*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on 3 mil film ▶ Works well on sealer sanding, primer and e-coat scuff applications 	 <p>360L*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on 3 mil film ▶ Ideal for composite, primer and gelcoat applications where finish is crucial 	 <p>375L/371L*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on 5 or 3 mil film ▶ A multi-purpose value disc where finish and durability are musts
 <p>468L*</p> <ul style="list-style-type: none"> ▶ Silicon Carbide on 3 mil film ▶ For light sanding that requires fast cut rate and consistent finishing 	 <p>268XA* <small>Specialized Applications</small></p> <ul style="list-style-type: none"> ▶ Microreplicated abrasive on 3 mil film ▶ Used in a variety of solid surface and AOEM tier prep for paint applications 	 <p>366L</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on 3 mil film ▶ A versatile disc that delivers in paint removal, prep for paint and solid surface finishing 	 <p>775L</p> <ul style="list-style-type: none"> ▶ Precision-Shaped Grain on 3 mil film ▶ The go-to choice for all applications that require premium performance 	 <p>675L</p> <ul style="list-style-type: none"> ▶ Diamond abrasive on 5 mil film ▶ Designed for finishing on hard materials and can be used for coating removal and prep










Lighter backing

Heavier backing

*Stearate-free

Paper backed sanding discs

Most versatility and most common backing type. Have good flexibility. Performance can range from value to top tier.

 <p>216U/210U*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on A-weight paper ▶ For light sanding and prep work on primers, paints, gelcoats and sealers 	 <p>401Q*/431Q*</p> <ul style="list-style-type: none"> ▶ Silicon Carbide on A or C-weight paper ▶ Can be run wet or dry in prep for buff or paint and in polishing applications 	 <p>732U</p> <ul style="list-style-type: none"> ▶ Precision-Shaped Grain on C-weight paper ▶ A premium choice for all applications that require fast cut and long life 	 <p>363i*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on F-weight paper ▶ A value disc designed for demanding applications on wood, composite and metal 	
 <p>426U</p> <ul style="list-style-type: none"> ▶ Silicon Carbide on A-weight paper ▶ A value product for wood sanding and applications where finish is critical 	 <p>236U</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide on C-weight paper ▶ The multi-purpose, multi-application value disc 	 <p>321U Blue</p> <ul style="list-style-type: none"> ▶ Ceramic and Aluminum Oxide blend ▶ A high performing general purpose price-value disc 	 <p>752i*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide and Ceramic blend on E-weight paper ▶ A great option for prep for paint in metal or deflashing/surface prep on composites 	 <p>763U*</p> <ul style="list-style-type: none"> ▶ Aluminum Oxide and Ceramic blend on F-weight Paper ▶ A robust disc ideal for heavy stock removal and refining metal scratches

















































Lighter backing

Heavier backing

*Stearate-free

Application Guide

The 3M recommendations below are starting points for the ideal system solutions. Be sure to conduct trials to find the right system for the application.

Application	Recommended Disc	Alternative Disc	Common Grades	Suggested Backup Pad	Suggested Tool Orbit	Process
Primer Sanding			180 – 400	Low Profile Finishing 	3/16" 	Sanding workpiece for consistent scratch prior to paint
Coating Removal			80 – 240	Red Low Profile 	3/8" 	Removing coatings from workpiece prior to application of primers and paints
Surface Refining/ Flattening			80 – 220	Red Low Profile 	3/16" 	Smoothing and leveling workpiece prior to paint for consistent paint adhesion
Deflashing Plastic			60 – 120	Red Low Profile 	3/16" 	Removing excessive plastic flash by knocking off sharp edges
Gelcoat Sanding			240 – 1000	Low Profile Finishing 	3/16" 	Flattening or removing defects in gelcoat while refining for following buff and polish or paint step
Removing Parting Lines			180 – 320	Red Low Profile 	3/16" 	Removing raised lines in manufacturing to blend surface geometry
Shaping			36 – 220	Yellow Standard 	5/16" 	Incremental steps of cutting and shaping refinement for composite fabrication
Whitewood Sanding			150 – 220	Red Low Profile 	3/16" 	Leveling or smoothing wood surface and removing machining marks from saw cuts or routers
Sealer Sanding			320 – 400	Low Profile Finishing 	3/32" 	Leveling orange peel and scuffing for adhesion of next layer of coatings or finish
Prep for Paint on Steel			80 – 120	Red Low Profile 	3/16" 	Refining a fiber disc scratch used in stock removal for an even scratch prior to paint
Removing Handling Scratches			80 – 120	Red Low Profile 	5/16" 	Identifying defects in metal parts caused by upstream handling
Edge Deburring			60 – 120	Yellow Standard 	5/16" 	Removing sharp edges on sheared metal

For applications needing a bright final finish, follow up with a Scotch-Brite™ Non-woven finishing disc.

