



Versatile, convenient and efficient, 3M manufactures a complete line of coated abrasives to handle all of your random orbital abrasive needs. From pressure-sensitive adhesive coating on the back, to traditional hook-and-loop style abrasives, 3M offers a variety of attachment systems to meet your challenging applications.

## Discs

## Selection Guide

|        | Product               | Mineral Type                      | Backing | Weight | Load-Resistant/<br>Grinding Aid | Substrate |            |               |        |                       |      |       | Application |          |           |           | Metal Type |              |                               |                 |
|--------|-----------------------|-----------------------------------|---------|--------|---------------------------------|-----------|------------|---------------|--------|-----------------------|------|-------|-------------|----------|-----------|-----------|------------|--------------|-------------------------------|-----------------|
|        |                       |                                   |         |        |                                 | Gel Coat  | Composites | Solid Surface | E-Coat | Primer/<br>Paint Prep | Wood | Metal | Grinding    | Blending | Deburring | Finishing | Aluminum   | Carbon Steel | Non-Ferrous<br>(Brass/Bronze) | Stainless Steel |
| Good   | NX                    | Aluminum Oxide                    | Paper   | C/D    | Y                               | •         | •          |               |        | •                     | •    | •     |             | •        | •         |           |            |              |                               |                 |
|        | 216U                  | Aluminum Oxide                    | Paper   | A      | Y                               | •         | •          | •             | •      | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 255L                  | Aluminum Oxide                    | Film    | Film   | Y                               | •         | •          | •             | •      | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 426U                  | Silicon Carbide                   | Paper   | A      | Y                               |           |            |               |        | •                     | •    | •     |             |          |           |           |            |              | •                             |                 |
| Better | 202DZ                 | Aluminum Oxide                    | Cloth   | J      | N                               |           |            |               |        |                       |      | •     | •           |          | •         | •         | •          |              |                               |                 |
|        | <b>UPGRADED!</b> 236U | Aluminum Oxide                    | Paper   | C      | Y                               | •         | •          | •             | •      | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 348D                  | Aluminum Oxide                    | Cloth   | X      | N                               |           |            |               |        |                       | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 360L                  | Aluminum Oxide                    | Film    | Film   | N                               | •         | •          | •             |        | •                     | •    |       |             |          |           | •         |            |              |                               |                 |
|        | 363I                  | Aluminum Oxide                    | Paper   | F      | N                               | •         | •          |               | •      | •                     | •    | •     |             | •        | •         |           | •          |              |                               |                 |
| Best   | <b>NEW!</b> 375L      | Aluminum Oxide                    | Film    | Film   | Y                               | •         | •          | •             | •      | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 366L                  | Aluminum Oxide                    | Film    | Film   | Y                               | •         | •          | •             |        | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 735U                  | Blended Ceramic<br>Aluminum Oxide | Paper   | C      | Y                               | •         | •          | •             |        | •                     | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 777F                  | Aluminum Oxide                    | Cloth   | Y      | Y                               |           |            |               |        |                       | •    | •     |             | •        | •         |           | •          | •            | •                             |                 |
|        | 900DZ                 | Ceramic                           | Cloth   | J      | N                               |           | •          |               | •      | •                     | •    | •     |             | •        | •         |           | •          | •            |                               |                 |

## Random Orbital Sanding – Unfinished Wood

### Application Information: 3M™ Stikit™ and Hookit™ Positioning Chart

| Substrate | Backing | Stock Removal (Dimensioning)<br>Grades 60–80 | Medium Stock Removal (Intermediate Sanding)<br>Grades P100–P150 | Finishing (Defect Removal)<br>Grades P180 and Finer |
|-----------|---------|--|---|---|
| Hardwoods | Cloth   | 202DZ, 900DZ                                 | 202DZ, 900DZ  | 202DZ, 900DZ  |
|           | Film    | 255L, 366L, <b>375L NEW!</b>                 | 255L, 366L, <b>375L NEW!</b>                                    | 255L, 366L, <b>375L NEW!</b>                        |
|           | Paper   | NX, 236U, 363I, 735U                         | NX, 236U, 735U  | NX, 236U, 426U, 735U                                |
| Softwoods | Cloth   | 202DZ, 900DZ                                 | 202DZ, 900DZ  | 202DZ, 900DZ  |
|           | Film    | 255L, 366L, <b>375L NEW!</b>                 | 255L, 366L, <b>375L NEW!</b>                                    | 255L, 366L, <b>375L NEW!</b>                        |
|           | Paper   | NX, 236U, 363I, 735U                         | NX, 236U, 735U  | NX, 236U, 426U, 735U                                |

### Starting Point Recommendations

#### Step 1

Initial sanding should level the work piece if not previously sanded by a wide belt machine. For quick leveling and aggressive, coarse sanding operations, use a disc in grade 80 or 100.

#### Step 2

Intermediate sanding should use a disc in grade 120 or 150, depending on the abrasive grade used on the previous step. It is recommended to skip no more than one grade between sanding steps.

#### Step 3

Recommend finishing using either grade 180 or 220. The wood type, machine parameters and finish used will determine the appropriate abrasive grade.

| Work Piece  | Hardwood       |           |           | Softwood  |           |           |           |
|---|----------------|-----------|-----------|-----------|-----------|-----------|-----------|
|   | Starting Point | Step 1    | Step 2    | Step 3    | Step 1    | Step 2    | Step 3    |
| <b>Heavy Sanding (required):</b> has a 60 or 80 grit wide belt finish or an 80 grit Random Orbital Sander finish          | 735U P100      | 735U P150 | 255L P220 | 426U 180* | 735U P100 | 735U P120 | 735U P180 |
| <b>Intermediate Sanding (required):</b> has a 100 or 120 grit wide belt finish or a 120 grit Random Orbital Sander finish | 735U P150      | 255L P220 | 426U 180* |           | 735U P180 | 426U 180* |           |
| <b>Light Sanding (required):</b> has a 150–180 grit wide belt finish or a 150 grit Random Orbital Sander finish           | 426U 180*      |           |           |           | 735U P180 | 426U 180* |           |

\*426U is a final step option when finish is the most critical criteria.

When a finer finish is required for very hard woods such as hard maple or hickory, it might be necessary to use a disc that is one grade finer for the final step.

## 3M™ Stikit™ Discs and Disc Rolls – Paper Best

### 3M™ Stikit™ Paper Disc Roll 735U

- C wt. paper
- Load resistant coating
- Sharp-cutting and durable
- Ideal for wood, soft metals, fiberglass and solid surface
- Convenient disc roll form



| UPC Number     | Diameter | Grade | Disc/Roll | Min/Case |
|----------------|----------|-------|-----------|----------|
| 051111-51229-6 | 5" x NH  | P80   | 100       | 1/4      |
| 051111-51231-9 | 5" x NH  | P120  | 100       | 1/4      |
| 051111-51232-6 | 5" x NH  | P150  | 100       | 1/4      |
| 051111-51233-3 | 5" x NH  | P180  | 100       | 1/4      |
| 051111-51234-0 | 5" x NH  | P220  | 100       | 1/4      |

### 3M™ Stikit™ Tab Liner Disc 735U

- C wt. paper
- Load resistant coating
- Sharp-cutting and durable
- Ideal for wood, soft metals, fiberglass and solid surface



| UPC Number     | Diameter | Grade | Discs/Roll | Min/Case |
|----------------|----------|-------|------------|----------|
| 051141-20760-5 | 5" x NH  | P80   | 50         | 50/250   |
| 051141-20762-9 | 5" x NH  | P100  | 50         | 50/250   |
| 051141-20764-3 | 5" x NH  | P120  | 50         | 50/250   |
| 051141-20766-7 | 5" x NH  | P150  | 50         | 50/250   |
| 051141-20768-1 | 5" x NH  | P180  | 50         | 50/250   |
| 051141-20770-4 | 5" x NH  | P220  | 50         | 50/250   |
| 051141-24042-8 | 6" x NH  | P80   | 50         | 50/250   |
| 051141-24043-5 | 6" x NH  | P100  | 50         | 50/250   |
| 051141-24044-2 | 6" x NH  | P120  | 50         | 50/250   |
| 051141-24045-9 | 6" x NH  | P150  | 50         | 50/250   |
| 051141-24046-6 | 6" x NH  | P180  | 50         | 50/250   |
| 051141-24047-3 | 6" x NH  | P220  | 50         | 50/250   |

## 3M™ Stikit™ Discs and Disc Rolls – Film General Use

### 3M™ Stikit™ Gold Film Disc Roll 255L

- Aluminum oxide on a flexible, tear resistant film backing
- Load resistant coating
- Convenient disc roll form



| UPC Number     | Diameter | Grade | Discs/Roll | Min/Case |
|----------------|----------|-------|------------|----------|
| 051144-82471-7 | 5" x NH  | P80   | 100        | 1/4      |
| 051144-82470-0 | 5" x NH  | P100  | 125        | 1/4      |
| 051144-82469-4 | 5" x NH  | P120  | 125        | 1/4      |
| 051144-82468-7 | 5" x NH  | P150  | 125        | 1/4      |
| 051144-82467-0 | 5" x NH  | P180  | 125        | 1/4      |
| 051144-82466-3 | 5" x NH  | P220  | 125        | 1/4      |
| 051144-82465-6 | 5" x NH  | P240  | 125        | 1/4      |
| 051144-82464-9 | 5" x NH  | P280  | 125        | 1/4      |
| 051144-82463-2 | 5" x NH  | P320  | 125        | 1/4      |
| 051144-82461-8 | 5" x NH  | P400  | 125        | 1/4      |
| 051131-01363-6 | 6" x NH  | P80   | 100        | 1/4      |
| 051131-01362-9 | 6" x NH  | P100  | 125        | 1/4      |
| 051131-01361-2 | 6" x NH  | P120  | 125        | 1/4      |
| 051131-01360-5 | 6" x NH  | P150  | 125        | 1/4      |
| 051131-01359-9 | 6" x NH  | P180  | 125        | 1/4      |
| 051131-01358-2 | 6" x NH  | P220  | 125        | 1/4      |
| 051131-01357-5 | 6" x NH  | P240  | 125        | 1/4      |
| 051131-01356-8 | 6" x NH  | P280  | 125        | 1/4      |