

Great stainless steel finishes in just 5 steps... The 3M way...

In 5 easy steps using the 3M finishing system, you can grind and blend welds to the best and customize the finish.



Step 1

Levelling the Weld

3M recommends 3M™ Flexible Green Corps™ or 3M™ Radial Flap Disc.



Step 2

Scratch Removal

Set the directional grain line with a 3M™ Cubitron™ Abrasive Grain Cloth Belt. 3M recommends 777F, Grade P120.



Step 3

Setting the Grain

Use 3M™ Trizact™ belt to prepare surface for final finish.



Step 4

Final Finishing

By using a combination or stand alone of belt and Combiflap™ Brush systems, unique dull and hairline finishes can be generated.



Step 5

Blending & Touch up

Use a Scotch-Brite™ Hand Pad 7446 for final blending and touch-up of stainless steel finishing.

One source for abrasives and tools better finish, better service

Presenting the complete 3M system of tools and accessories to make your finishing jobs simpler and easier...



3M™ Cutoff Wheel Tools

3M™ Cutoff wheel tool, is designed to cut faster, less vibrations & for cool running. These tools are designed with:

- High output air motor
- Direction exhaust
- 3M™ Greptile™ Grip
- Safety lever throttle to avoid accidental starting
- 4 Place indexable head
- 360 Degree rotatable safety guard



3M™ Disc Sanders

3M has come up with Disc sanders/Roloc™ tool that offers a better working position to reduce load on the wrist. This tool is easy to operate, handle and to use. This tools is designed with:

- High output air motor
- Direction exhaust
- 3M™ Greptile™ Grip
- Safety lever throttle to avoid accidental starting
- 4 Place indexable head
- 97° head allows for more comfortable wrist position



3M™ Inline Sanders

3M™ Inline Sanders are designed to generate straight line scratches for finishing stainless steel. These sanders coupled with the new Expander wheels of 3M gives a system that is easy to handle and use.

The expander wheels' slotted rubber drum expand during operation; keeping the belt tight while finishing steel. These wheels have an attachment for affixing them to inline sanders.

Stainless Steel Finishing Systems



Styling Steel

With 3M Abrasive Systems

We have the abrasive solutions and tools that help you deliver a quality finish.

3M

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Step 1 WELD GRINDING

Using the following products for weld leveling helps prepare stainless steel for further finishing steps.

Recommended starting points:

3M™ Green Corps™ Flexible Grinding discs

- Cuts faster
- Better finish
- Does not leave any black marks while grinding because of minimal heat build up
- Lesser tool vibrations hence lower tool maintenance cost

Available in 4", 5" & 7" sizes and in grits of 36, 60 & 80.

3M™ Radial Flap Disc 747D & 563D

- Best suited for corner weld grinding
- Smooth finish
- Minimal heat buildup
- Lesser material gouging

Available in two minerals - Cubitron™ (747D) & Alumina Zirkonia (563D)
Available in 4" & 4.5" and in grits of 40,60,80 & 120.

3M™ Roloc™ Discs 777F

- Best suited for spot weld grinding
- Can grind weld in tight corners
- Gives a finer finish
- Can be easily fitted to a 4" angle grinding machine with the backup pad

Available in 2" & 3" and in 36,60,80 & 120 Grit.

RIGHT ANGLE WELD GRINDING

3M offers a complete system using coated abrasive and surface conditioning belts for leveling, blending and finishing right angle welds on stainless steel. The advantages of this system are:

- Easier access
- Faster stock removal
- Less undercutting

Step 2 FINISHING

Once the weld is leveled, the finishing of steel can be started.

Step 1 Scratch Removal

These product options generate a directional scratch that will prepare stainless steel for final finishing.

3M™ 777F P120 belt

- Removes the surface coat of the 2B Sheet and creates a uniform scratch pattern
- Contains a grinding aid which enhances performance on stainless steel

It is recommended to use 3M™ Roloc™ 777F P120, followed by 3M™ Scotch-Brite™ AMED / AVFN 3" Roloc™ for removing any deep scratches on stainless steel.

Step 2 Setting the Grain

3M™ Trizact™ A160 belt

Trizact™ abrasives are made by micro replication methodology giving a uniform distribution of abrasives on the entire surface of the belt. This gives:

- Consistent finish
- Consistent performance
- Prepares surface for final finish

Step 3 Final Finishing

3M abrasives can provide various dull and hairline finishes. These finishes can be achieved by using Scotch-Brite™ belts, Combi™/flap brush or a combination of both. The advantages of these systems are:

- Easy to use
- Operator skill independent
- Fits the same machine

3M offers in Scotch-Brite™ belt solutions AMED, AVFN and SSFN in the sizes 3½" x 15½"

Productivity Tip: If the sheet has less scratches, to save time, the finishing cycle can directly start with Step 2.

Step 4 Blending & Touch up

Blending:

Once the final finishing cycle is completed, for any tight corners & non-reachable areas, it is recommended to use SS Finishing Handpads.

Touch up:

It is recommended to use the 3M Stainless Steel Cleaner & Polish spray in order to protect the generated finish against any operator hand marks, grease, etc. This gives temporary protection.

3M SOLUTIONS FOR OTHER APPLICATIONS

WELD CLEANING

For weld cleaning, it is recommended to use abrasives that only clean the weld without removing any weld. From the 3M vast abrasives range Clean & Strip™ Wheels and Radial Bristle disc can be used for weld cleaning applications. Available in 6" diameter and in grits of 80, 120 and 220.

PIPE FINISHING

3M offers of the Belt solutions for finishing of the pipes / rods. The same steps for finishing the sheets can be replicated.