

# 3M™ Cubitron™ Abrasives

## Product Guide - Medium Pressure Grinding

**3M 707E:** 'JE' weight flexible, suitable for refining applications where conformability is required. Available up to P240 for intermediate finishing on stainless steel and cobalt chrome. Features a grinding aid for cooler cutting.

**3M 747D:** 'X' weight semi-flexible belt. Features grinding aid for cooler cutting.

**3M 777F:** 'YF' weight stiff, suitable for grinding applications. Can be run wet. Features grinding aid for cooler grinding.

**3M 907E:** 'JE' weight flexible, suitable for casting skin removal and blending applications where conformability is required. Features grinding aid for cooler cutting.

**3M 947D:** 'X' weight semi-flexible. High performance product for stock removal and blending applications on cobalt chrome and nickel alloys. Suitable for portable hand tools and backstand machines. Features grinding aid for cooler cutting.

**3M 964F:** 'YF' weight stiff, suitable for grinding and blending applications. Can be run wet. Designed to produce superior grinding and blending on mild steel, tool steels and SG iron. Also suitable for aluminium substrates.

# 3M™ Cubitron™ Abrasives

## Product Guide - High Pressure Grinding

**3M 967F:** 'YF' weight backing, suitable for high pressure grinding applications. Designed for superior offhand and pressure-assisted grinding of hard-to-grind, heat-sensitive alloys – the product of choice for titanium. Features grinding aid for cooler grinding.

**3M 974F:** 'YF' weight backing, suitable for high pressure grinding applications. Aluminium Foundry belt, designed with excellent mineral edge retention for tough edge grinding on aluminium.

**3M 977F:** 'YF' weight backing, suitable for high pressure grinding applications on stainless steel and product of choice for stainless steel and other foundry grinding applications. Can be run wet. Features grinding aid for cooler grinding.

**3M 987FI:** **NEW** high performance Cubitron mineral. 'YF' weight backing, excellent for high pressure grinding in P36. Designed for grinding heat sensitive metals such as Nickel Alloy. Delivers a cooler, faster cut with less operator effort on manual off hand machines. Can be run wet.

## 3M Abrasive Systems Abrasive Belt Application Guide



# 3M

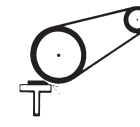
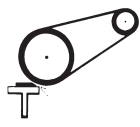
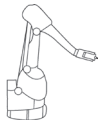
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# 3M



Machine Type Material	Robotic	Portable File Belt Machines	Power Grinding (High Pressure)	Toolpost Linisher Dry	Stroke Sander	Platen Sander	Backstand (Pressures)		Centreless & Flat Finisher	
							Medium	Light	Dry	Wet
Mild Steel		947D 964F		964F	747D	964F	964F	964F	977F	977F
Tool Steels & SG Iron	964F	947D 964F	967F	964F		964F	967F 977F	964F	977F	977F
Stainless & Cobalt	907E 987FI	777F 947D 977F	967F 987FI	977F	747D 907E 947D	707E 777F 907E 947D	947D 967F 977F	907E 947D 777F	977F	977F
Aluminium		777F 964F	974F	964F			964F 974F	964F	964F	
Nickel Alloys	967F 987FI	947D 977F 987FI	987FI	977F		777F 907E	947D 967F 987FI	947D 907E 987FI	977F	977F
Titanium	967F	977F	967F				967F	967F		977F

3M Code	3M 707E	3M 747D	3M 777F	3M 907E	3M 947D	3M 964F	3M 967F	3M 974F	3M 977F	3M 987FI
Backing Type	Flexible JE wt.	Semi-Flexible X wt.	YF wt.	Flexible JE wt.	Semi-Flexible X wt.	YF wt.	YF wt.	YF wt.	YF wt.	YF wt.
Grinding Aid	Yes	Yes	Yes	Yes	Yes	No	Yes	No	Yes	Yes
Use: Dry / Wet	Dry	Dry	Dry/Wet	Dry	Dry	Dry/Wet	Dry	Dry	Dry/Wet	Dry/Wet
Pressure	Medium	Medium	Medium	Medium	Medium	Medium	High	High	High	High
Grit Range	P240	■								
	P220	■								
	P180	■		■						
	P150	■	■	■	■					
	P120	■	■	■	■	■			■	
	P100	■	■	■	■	■			■	
	P80	■	■	■	■	■	■	■	■	■
	P60		■	■	■	■	■	■	■	■
	P50		■	■			■	■	■	■
	P40			■			■	■	■	■
	P36			■			■	■	■	■
	P24						■	■		■