

Scotch-Brite™

Flap Brushes

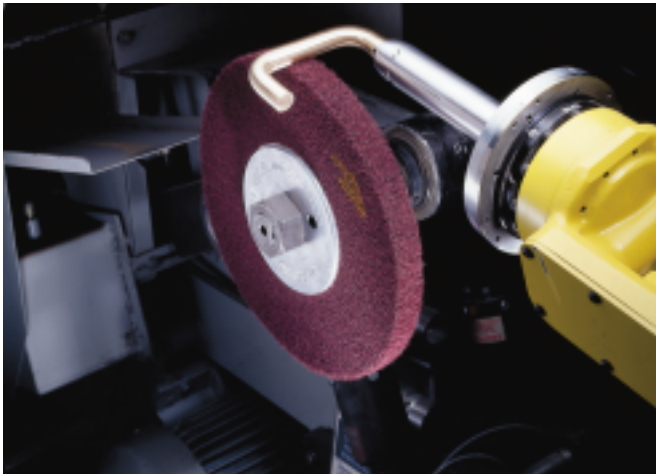
*Versatility for finishing and deburring
metal, plastics, wood, and more*

Upgraded
Balance
and
Consistency



3M *Innovation*

Scotch-Brite™ Finishing Flap Brushes



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Your primary choice when conformability and very uniform finish is critical. Optimal performance when run under 3000 surface feet per minute in dry applications.

Applications:

- Satin finishing on extrusions and builder's hardware
- Buffing and bright finishing
- Jewelry finishing on bench motors
- Defuzzing and edge sanding for wood and mouldings
- Cleaner alternative to buffs and compounds

Product Availability:

Mineral Type	Brush Color	Grade
Aluminum Oxide	Maroon	VFN, FIN, MED, CRS
Silicon Carbide	Gray	ULF, SFN, VFN, FIN, MED

Diameter: 6"-16"

Center Hole: 2", 3", 5", 8", 10"

Widths: 3/4"-32" (or up to 66" with steel core)

Densities: 3, 5, 7

Application Guidelines

Scotch-Brite™ brushes are used by manufacturers of hand tools, surgical equipment, stamped metal parts, transportation vehicles, builders hardware, plastic products, mouldings, and other woodworking products, and much more. Aerospace component manufacturers condition surfaces of blades, vanes, rotors, fasteners, nozzles, extrusions and airframe supports. In maintenance and repair, Scotch-Brite brushes are used to clean and condition surfaces properly and efficiently.

Scotch-Brite™ High Strength Flap Brushes



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Durable construction when you need aggressive blending and finishing, or when higher speeds are necessary.

Applications:

- Graining stainless steel using a straight shaft tool
- Blending handling marks and imperfections
- Ideal for deburring when conformability is necessary
- Cleaning around welds
- Antique finishes that highlight and leave recessed areas dark

Product Availability:

Mineral Type	Brush Color	Grade
Aluminum Oxide	Maroon	VFN, FIN, MED

Diameter: 6"-16"

Center Hole: 2", 3", 5", 8", 10"

Widths: 3/4"-32" (or up to 66" with steel core)

Densities: 3, 5, 7

Consider your operating conditions when selecting Scotch-Brite™ brushes:

- Composition of part/material type
- Material hardness
- Work to be performed
- Surface area to be conditioned
- Part variability
- Tool and machinery types and speed
- Applied pressure
- Surface temperature of part

Scotch-Brite™ Cut & Polish Flap Brushes



Most aggressive Scotch-Brite flap brush producing the most uniform, highest scratch density.

Applications:

- Deburring a variety of substrates mounted on a backstand or bench motor
- Light cleaning of surface residues or discoloration
- Removing oxides for surface preparation
- Graining and blending handling marks
- Final mould sanding and defuzzing
- Used mounted on backstand or bench motor

Product Availability:

Mineral Type	Brush Color	Grade
Aluminum Oxide	Tan	VFN, MED

Diameter: 6"-16"

Center Hole: 2", 3", 4", 5", 8", 10"

Widths: 3/4"-32" (or up to 66" with steel core)

Densities: 3, 5, 7

Hardware required: Flanges are offered for adapting Scotch-Brite™ brushes to standard production equipment. Typical flanges include #349 for 2" CH brushes and #356 for 3", 4", 5", 8", 10" CH brushes. To order, specify your brush CH for flange O.D. by your spindle size for flange I.D. Example: #356 flange 3" x 3/4".

Coolants and grinding aids: Although these are not required for most applications, most common industrial grinding lubricants, coolants, and/or compounds can be used with Scotch-Brite Brushes if necessary.

Scotch-Brite™ Combi Flap Brushes



Combines cutting action of 3M™ coated abrasive with finishing action of Scotch-Brite non-woven material for finishing woods and other materials in a single step. These brushes can be shaped by sanding the moulding while the moulding is covered with a piece of adhesive backed sandpaper (60 grit).

Applications:

- Defuzzing/denibbing MDF and wood mouldings
- Used between primer and topcoat sanding to smooth fibers
- Breaking sharp edges
- Sealer scuffing
- Used on a vertical spindle sander or in an automated line

Product Availability:

Mineral Type	Brush Color	Sandpaper Grade
Silicon Carbide	Gray	150, 180, 220, 320 grade paper alternating with silicon carbide Scotch-Brite non-woven flaps

Diameter: 8"

Center Hole: 3"

Widths: 3/4"-32"

Density: 7

Technical Information

Maximum operating speed: Brushes must be operated within specified maximum operating speeds (M.O.S.). Refer to the recommended operating speed chart for specific recommendations, which usually is less than the M.O.S.

Ordering Information

To order: State product name, density, mineral type, grade, diameter x width x center hole. Example: Scotch-Brite™ Finishing Flap Brushes, 5A-medium, 8" x 3".

Mineral grade abbreviations: CRS = Coarse, MED = Medium, FIN = Fine, VFN = Very fine, SFN = Super fine, ULF = Ultra fine

Technical Information

Surface Speed Conversion Chart

RPM at Arbor or Spindle	Diameter of Wheels					
	6"	8"	10"	12"	14"	16"
Surface Speed in Feet Per Minute (SFPM)						
500	785	1045	1310	1570	1820	2094
600	940	1255	1570	1885	2195	2513
700	1100	1465	1835	2200	2560	2932
800	1256	1675	2094	2513	2932	3351
900	1413	1885	2356	2827	3298	3770
1000	1570	2094	2618	3141	3665	4189
1100	1727	2304	2880	3455	4031	4608
1200	1884	2513	3142	3769	4398	5027
1300	2042	2723	3404	4084	4764	5445
1400	2199	2932	3666	4398	5131	5864
1500	2356	3142	3927	4712	5497	6283
1600	2513	3351	4189	5026	5864	6702
1700	2670	3560	4451	5340	6230	7121
1800	2827	3770	4713	5650	6597	7540
1900	2984	3979	4975	5969	6963	7959
2000	3141	4189	5236	6283	7330	8378
2100	3298	4398	5498	6497	7696	8796
2200	3455	4608	5760	6911	8063	9215
2300	3612	4817	6022	7225	8429	9634
2400	3770	5027	6284	7540	8796	10053
2500	3927	5236	6545	7854	9162	10472
2600	4084	5445	6807	8168	9529	10891
2700	4241	5655	7069	8482	9895	11310
2800	4398	5864	7331	8796	10262	11729
2900	4555	6074	7592	9110	10629	12148
3000	4712	6283	7854	9425	10996	12566
3200	5026	6702	8378	10053	11729	13404
3400	5340	7121	8901	10681	12462	14242
3600	5654	7539	9425	11309	13193	15080
3800	5969	7958	9948	11938	13927	15917
4000	6283	8377	10472	12566	14661	16755

Scotch-Brite™ Brush Aggressiveness		Scotch-Brite™ Brush Durability	
Most	Cut and Polish	Most	High Strength
	Combi		Cut and Polish
	High Strength		Combi
Least	Finishing	Least	Finishing

Recommended Operating Speeds

Diameter of Brushes	SFPM
Decorative Finishing*	500-3000
Composites / Soft Materials	1200-2700
Cleaning and Conditioning	2000-5000
Prepolishing	2000-7000
Oxide Removal	4500-6500
Deburring	5000-6500
Wood Sanding	500-2500

*Finishing Flap Brushes should not be run over 3500 SFPM

Maximum Operating Speeds (RPM)

Diameter	CP-FB	CF-FB	HS-FB	CB-FB
6"	4,000	3,400	3,400	3,400
8"	4,000	3,200	3,200	3,200
10"	3,200	2,500	2,500	2,500
12"	2,700	2,500	2,500	2,500
14"	2,000	2,000	2,000	2,000
16"	1,900	1,500	1,500	1,500

CP-FB = Cut and Polish Flap Brush

CF-FB = Finishing Flap Brush

HS-FB = High Strength Flap Brush

CB-FB = Combi Flap Brush

For more information and assistance:

Contact your local 3M abrasive products distributor or 3M.

Contiguous 48 United States	1-800-742-9546
Fax	1-800-852-4668
Alaska	907-522-5200
Canada	519-451-2500
Hawaii	808-422-2721
Northern Mexico	526-647-6000
Puerto Rico	809-750-3000

IMPORTANT NOTICE TO PURCHASER

Product Use: User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application.

3M warrants that its abrasive products will be free from defects in materials and manufacture. If an abrasive product is proved to be defective, then the exclusive remedy, and 3M's sole obligation shall be, at 3M's option, to replace the quantity of the product which is proved to be defective or to refund the purchase price.

Warranty and Limited Remedy: 3M makes no other warranties, express or implied, INCLUDING, BUT NOT LIMITED TO ANY IMPLIED WARRANTY OF MERCHANTABILITY, OF FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.

Limitation of Liability: 3M shall not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including, but not limited to, warranty, contract, negligence or strict liability.

The foregoing Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of 3M.

Safety Information: Always use appropriate protective glasses, face shields and body protection. Do not exceed maximum operating RPM's. Use guards provided with machine. Follow safety operation procedures posted in work areas.



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including 10% post-consumer waste paper.

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61-5002-8006-2(1211)JR