

3M | Cubitron™ 3
Performance Abrasives

FINISHING STRONG
Scotch-Brite™ BRAND
SINCE 1958

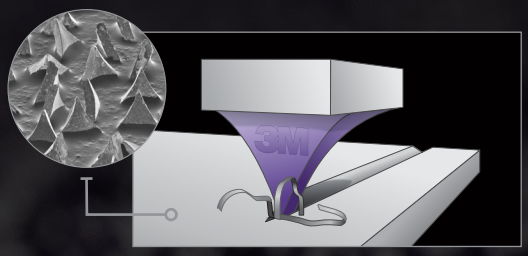
Produce more. With less.

Heavy Grinding and Cutting Application Guide

Featuring:

3M™ Cubitron™ 3 Performance Abrasives and Scotch-Brite™ Nonwoven Abrasive Products

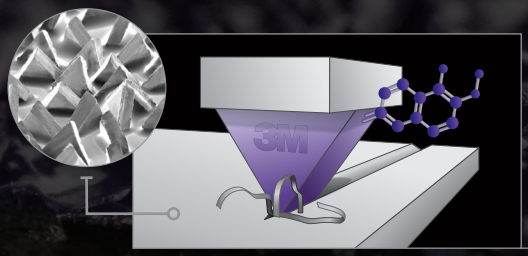
The science of 3M re-engineered Precision-Shaped Grain.



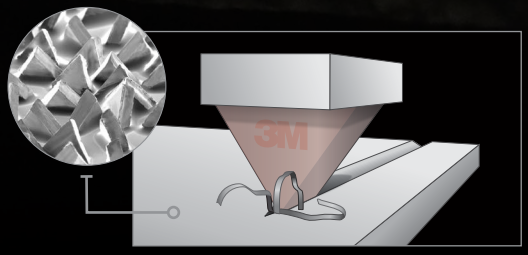
3M Cubitron™ 3 Performance Abrasives

Our latest 3M Precision-Shaped Grain

Re-engineered precision-shaped ceramic grain using a proprietary breakthrough in grain shape with curved sides. This helps increase productivity and lower overall grinding costs.



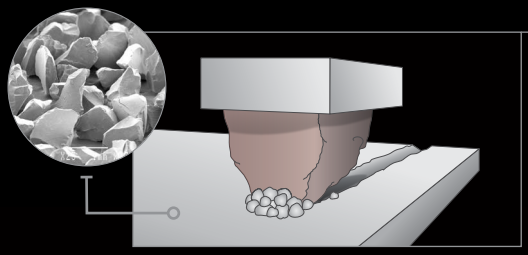
Re-engineered precision-shaped ceramic grain using proprietary breakthroughs in molecular bonded technology.



3M Cubitron™ 2 Performance Abrasives

3M Precision-Shaped Grain

3M pioneered the first precision-shaped grain using 3M microreplication technology to form consistent sharp peaks that easily "slice" through metal—cutting cooler, faster, and lasting longer than conventional abrasive grain.



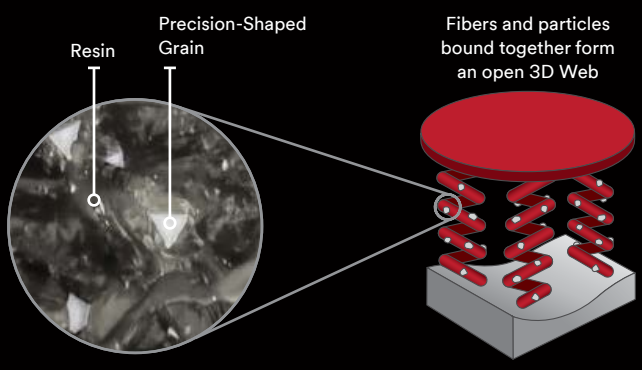
Conventional ceramic abrasive

Conventional ceramic abrasive grain tends to "plow" through metal, causing heat to build up in the workpiece and abrasive, resulting in a slower cut and shorter abrasive life compared to our latest precision-shaped grain.

FINISHING STRONG Scotch-Brite™ BRAND SINCE 1958

3M Precision-Shaped Grain and Nonwoven Abrasives

Combine benefits of two 3M technologies that can clean and finish surfaces without changing material geometry or dimension. You get a product that's soft enough to reduce defects but wears like iron without sacrificing the smooth feel and control you expect from Scotch-Brite™ Products.



The advantages of our cutting edge abrasive grain technology delivers measurable benefits for our customers.



The transformative power of technology.

Productivity Delivered

Enhanced Productivity

With a significantly faster cut rate, this technology helps manufacturers to process more parts with smaller workforces, helping boost efficiency and output.

Safety Built In

Improved Worker Safety

Reduced hand-arm vibration and noise prioritize the well-being of employees, helping employers develop better working conditions.

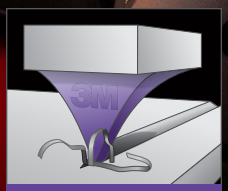
Sustainably Forward

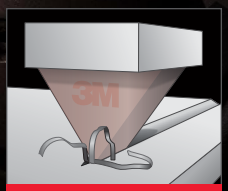
Sustainability at the Core

Longer-lasting abrasives and eco-friendly packaging align with the industry's sustainability objectives, helping to reduce carbon footprints and waste.

3M | Cubitron™ 3
Performance Abrasives

Fibre Discs


Cubitron™ 3


Cubitron™ 2

Breakthroughs in technology are redefining the limits of cut rate and total stock removal, with a focus on prioritizing productivity, safety, sustainability and optimizing automation.



3M™ Cubitron™ 3 Fibre Disc 1182C
For carbon steel



3M™ Cubitron™ 3 Fibre Disc 1187C
Includes grinding aid for stainless steel

11–Series Discs & Roloc™			
Grade	36+	60+	80+

- ✓ Beveling
- ✓ Surface Grinding
- ✓ Flame Cut Smoothing
- ✓ Weld Grinding

1182C, 36+ up to
3X
Faster Initial Cut Rate[1]
vs. Competitive High-Quality Grinding Wheel

1182C, 36+ up to
60%
More Life More Speed[2]
vs. 3M™ Cubitron™ 2 Fibre Disc 982C, 36+

1182C up to
88% **Less Vibration Exposure[3]**

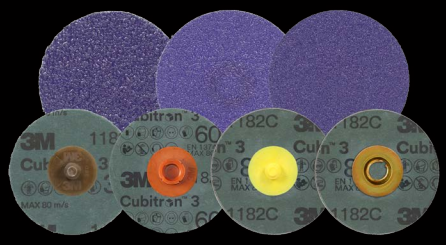
70% **Less Noise Energy[4]**
vs. Competitive High-Quality Grinding Wheel

Scan for more detailed product ordering info ▶
1182C 1187C

Learn about the Full System Advantage on page 11.

3M™ Cubitron™ 3 Roloc™ Fibre Discs

Disc buttons are color-coded when needed to identify its grade, making it easy to select the grade required for different applications from corner or curved surfaces to removing weld splatter on small areas.



CB3 Fibre Disc	Color	Grade
1184F Durable edge	White	All*
1184F	Brown	36+
1182C	Orange	60+
1187C	Yellow	80+

Flap Discs



3M™ Cubitron™ 3 Flap Disc 1169F
Ideal for use on carbon steel, stainless steel, and other heat-sensitive alloys

Grade	40+	60+	80+

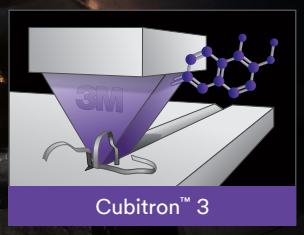
- ✓ Weld Removal
- ✓ Finishing
- ✓ Blending
- ✓ Deburring
- ✓ Surface Preparation
- ✓ Deburring Edges
- ✓ Weld Preparation
- ✓ Sanding
- ✓ Edge Beveling
- ✓ Weld Grinding

Scan for more detailed product ordering info ▼

Up to **82%** **More Material Removed[5]**
on carbon steel vs. a leading competitive alumina zirconia flap disc grade 40

Up to **85%** **Faster Sustained Cut Rate[5]**
on carbon steel vs. a leading competitive alumina zirconia flap disc grade 40

3M | Cubitron™ 3
Performance Abrasives



Cut-Off and Grinding Wheels

Using re-engineered Precision-Shaped Grain with new molecular bonding technology and sharp, angular structures that continuously fracture to form sharp points to wear evenly, run cool and optimize mineral breakdown.



3M™ Cubitron™ 3 Cut-Off Wheels
For carbon and stainless steel

Up to **3X** More Life[6]
10% More Speed[6]
vs. 3M™ Cubitron™ 2 Cut-Off Wheels

Up to **33%** Less Vibration[7]
vs. Competitive Ceramic Grain Wheels

- ✓ For ultra-fast cutting through sheet metal, metal tubing and more

Scan for more detailed product ordering info

Designed for exceptional life and speed in heavy-duty grinding applications on stainless steel, mild steel and other specialist alloys.



3M™ Cubitron™ 3 Depressed Center Grinding Wheels
For carbon and stainless steel

Up to **50%** More Life[8]
14% More Speed[8]
vs. 3M™ Cubitron™ 2 Depressed Center Grinding Wheels

Up to **33%** Less Vibration[9]
vs. Competitive Ceramic Grain Wheels

- ✓ Beveling
- ✓ Surface Grinding
- ✓ Weld Grinding
- ✓ Gouging
- ✓ Flame Cut Smoothing

Fast and versatile — designed to be used both as a grinding wheel and as a cut-off wheel on stainless steel, mild steel and other specialist alloys.



3M™ Cubitron™ 3 Cut & Grind Wheels
For carbon and stainless steel

Up to **5%** More Speed[10]
vs. 3M™ Cubitron™ 2 Cut & Grind Wheels

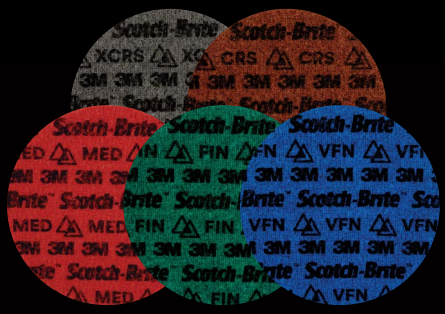
Better Balance | More Speed
We've reformulated the product to further improve ergonomics vs. Cubitron™ 2

- ✓ All the combined applications of grinding and cut-off wheels



Surface Conditioning Discs

For surface finishing after heavy grinding.



Scotch-Brite™ Precision Surface Conditioning Discs

3M Precision-Shaped Grain

Grades			
	VFIN	FIN	MED
	CRS	XCRS	

Contains 3M Precision-Shaped Grain for fast cut and long life.

Expanded grades for a large range of applications.

Balance of conformability and durability.

Bright, vivid colors help to identify easier.

Up to **40%** More Speed[11]

Up to **2X** More Life[12]

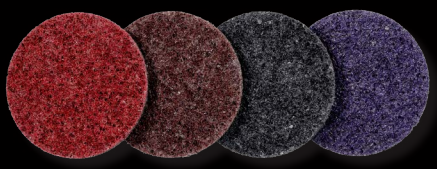
vs. Competitive CRS Discs

Attachment Types

Roloc™ | TN Quick Change | 7/8 Center Hole | Hook and Loop

- ✓ Light Grinding
- ✓ Deburring
- ✓ Blending
- ✓ Refining
- ✓ Cleaning
- ✓ Finishing

Scan for more detailed product ordering info



Scotch-Brite™ Precision Heavy Duty Surface Conditioning Discs

3M Precision-Shaped Grain

Grades		
	MED	CRS
	XCRS	XCRS

Grinds and blends in one step.

Fast aggressive cut, long life and consistent finish.

Durable construction resists edge wear.

Attachment Types

Roloc™ | TN Quick Change | 7/8 Center Hole | Hook and Loop

- ✓ Light Grinding
- ✓ Blending
- ✓ Deburring
- ✓ Edge Break

Scan for more detailed product ordering info

Stripping Discs

For cleaning after heavy grinding.

Safety Built In

No steel wires or high impact particles that could injure workers.



Scotch-Brite™ Clean and Strip XT Pro Disc

Silicon Carbide Mineral

Grade	S XCS

Quickly removes rust, paint, mill scale, coatings from metal and leaves a fine finish.

Silicon carbide mineral cuts aggressively with low sparking.

Maintains workpiece shape.

Up to **90%** **Less Vibration**[13]

Up to **54%** **More Speed**[13]

vs. Crimped Wire Cup Brushes

Attachment Types

Roloc™ | TN Quick Change | Center Hole | 5/8–11

- ✓ Finishing
- ✓ Surface Preparation
- ✓ Light Scale Removal
- ✓ Coating Removal

Scan for more detailed product ordering info



Scotch-Brite™ Clean and Strip XT Pro Extra Cut Disc

Aluminum Oxide Mineral

Grade	A XCS

Heavy rust / rust pit removal without leaving divots, ideal for weld refinement and removing weld discoloration.

Aluminum oxide mineral cuts to bare metal quickly.

Resists chunking and loading, and performs well on edges.

Attachment Types

Roloc™ | TN Quick Change | Center Hole | 5/8–11

- ✓ Cleaning
- ✓ Surface Preparation
- ✓ Finishing

Product Selection by Application

2 Step
1. 3M | Cubitron™ 3
2. Scotch-Brite™



3M™ Cubitron™ 3 Fibre Discs

11-Series



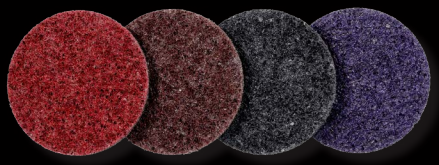
3M™ Fibre Discs

7-Series



Scotch-Brite™ Precision Surface Conditioning Discs

XCRS CRS MED FIN



Scotch-Brite™ Precision Heavy Duty Surface Conditioning Discs

MED CRS XCRS XXCRS

Flat Weld Grinding





Substrate	Mild Steel			Stainless Steel		
Weld Type	Large MIG	Med MIG	Small MIG	Large TIG	Med TIG	Small TIG
→ Start Here	1182C 36+	1182C 60+	1182C 80+	1187C 60+	1187C 80+	787C 120+ Precision XCRS
	3M™ Cubitron™ 3 Fibre Disc 11-Series 3M™ Fibre Disc 7-Series Scotch-Brite™ Precision Surface Conditioning Discs			For the ultimate in process speed and stock removal capability		
Pre-Finish Point	1	2	3	4	5	6

Surface Grinding





Substrate	Mild Steel			Stainless Steel		
Duty	Heavy	Med	Light	Heavy	Med	Light
→ Start Here	1182C 36+	1182C 60+	1182C 80+	1187C 60+	1187C 80+	787C 120+ Precision XCRS
	3M™ Cubitron™ 3 Fibre Disc 11-Series 3M™ Fibre Disc 7-Series Scotch-Brite™ Precision Surface Conditioning Discs			For the ultimate in process speed and stock removal capability		
Pre-Finish Point	1	2	3	4	5	6

Finish after Weld/ Surface Grinding



Following the grinding step with these innovative finishing products in as few as just one extra step.

Mild Steel Pre-Finish Point (Coating Thickness / Ra)		+3 mil / 1.23 Ra	+2 mil / 0.61 Ra	+1.5 mil / 0.5 Ra
→	1	Precision XCRS	Rarely required	Rarely required
	2	Precision XCRS	Precision CRS	Precision MED
	3	Rarely required	Precision CRS	Precision MED

Stainless Steel Pre-Finish Point (Ra)		0.8 Ra	0.6 Ra	0.4 Ra
→	4	Precision XCRS	Precision MED	Precision FIN
	5		Precision MED	Precision FIN
	6		Precision MED	Precision FIN

Alternatives to Fibre Discs in these applications

While we propose 3M™ Cubitron™ 3 Fibre Discs as the recommended solution for these applications, sometimes a strong preference for Grinding Wheels or Flap Discs remains. This could be due to the greater range of applications they can be used for. 3M™ Cubitron™ 3 Depressed Center Grinding Wheels or 3M™ Cubitron™ 2 Flap Discs are available providing exceptional cut speed and life.



3M™ Cubitron™ 3 Depressed Center Grinding Wheels



3M™ Cubitron™ 3 Flap Disc 1169F

Need more durability?

For outer corners and sharp edges switch to Scotch-Brite™ Precision Heavy Duty.



Removing paint or surface prep, use the Scotch-Brite™ Clean and Strip XT Pro.



Product Selection by Application



3M™ Cubitron™ 3 Depressed Center Grinding Wheels

Type 27



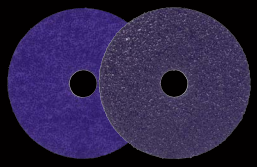
3M™ Cubitron™ 3 Cut & Grind Wheels

Type 27



Scotch-Brite™ Deburr & Finish Pro Unitized Wheel

9C XCRS+



3M™ Cubitron™ 3 Fibre Discs

11-Series

Fillet Weld Grinding

Substrate	Mild Steel			Stainless Steel		
Weld Type	Large MIG	Med MIG	Small MIG	Large TIG	Med TIG	Small TIG
Recommended	3M™ Cubitron™ 3 Depressed Center Grinding Wheel, Type 27 — Benchmark speed and life getting into corners			Scotch-Brite™ Deburr & Finish Pro Unitized Wheel, 9C XCRS+ — Aggressive cut with more control and low heat		

Beveling

Substrate	Mild Steel			Stainless Steel		
Gauge	Heavy	Med	Light	Heavy	Med	Light
Start Here	1182C 36+	1182C 60+	1182C 80+	1182C 60+	1182C 60+	1182C 80+
	3M™ Cubitron™ 3 Fibre Disc 11-Series — For the ultimate in process speed and stock removal capability					
Alternative	3M™ Cubitron™ 3 Depressed Center Grinding Wheel, Type 27 — Great speed and life with better application versatility					

Back Grinding and Gouging

Start Here	3M™ Cubitron™ 3 Depressed Center Grinding Wheel, Type 27	Minimum 7 mm gouge channel	Maximum stock removal speed
Alternative	3M™ Cubitron™ 3 Cut & Grind Wheel, Type 27	Either 3.2 mm or 4.2 mm gouge channel	More control

Cutting



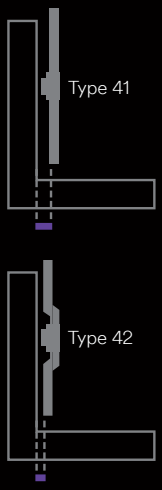
3M™ Cubitron™ 3 Cut-Off Wheel

Optimized for

- Carbon Steel
- Stainless Steel

Thickness (mm)	Metal
4.2	Heavy Gauge
3.2	
3.0	
2.5	
2.0	
1.6	
1.3	Thin Sheet
1.0	
0.8	

Could the customer increase wheel thickness? Cut rate will still be great, but the extra life will be worth it!





3M™ Cubitron™ 3 Wheels (Type 42) are ideal for cutting applications with difficult access.

3M | Cubitron™ 3
Performance Abrasives

Automation Ready

Get more value from your automation investment.

At 3M, we have a deep understanding of the factors that affect an automated abrasive process. Our 100+ years of abrasive experience and 35+ years of abrasive automation experience is accessible through our Technical Experts, our 17 Global Proof of Concept automation labs, and deployed into how we engineer our products.

Products engineered with automation in mind.

3M™ Cubitron™ 3 Performance Abrasives and Scotch-Brite™ Nonwoven Abrasives elevate product life, cut rate and wear consistency. This enhances processes that are already automated or increases the appeal of automating current manual ones.

Start your journey with 3M.

Download the 3M Automation and Robotics Handbook ▶



Tools that take it to the next level.

The 3M™ Pneumatic Angle Grinder and 3M™ Electric Angle Grinders are powerful tools that feature superior performance and world-class ergonomic designs. They're built with robust components for durability and reliability in the harshest industrial conditions.

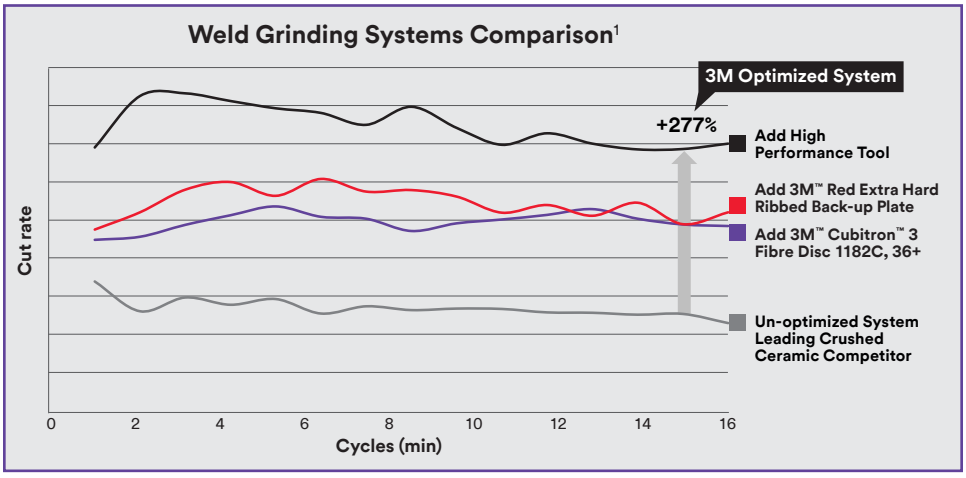
3M™ Pneumatic Angle Grinder Features:

- 1.5 HP (1100 W power)
- Wheel autobalancer
- Spindle lock
- Vibration-reducing side handle with added padding—interchangeable for right or left hand usage
- Available accessories provide maximum functionality and flexibility
- Rear exhaust directs exhaust and swarf away from the workpiece
- Adjustable guard

3M™ Electric Angle Grinder Features:

- 13 amp motor-delivers 1900 watts of power for demanding applications
- Soft start reduces torque during start up
- Dust filter helps reduce debris from entering the tool
- Lanyard attachment point offers the ability to secure tool when working at height
- Designed with two stage trigger, paddle switch and safety lever
- Kickback control shuts the tool down quickly

See the difference when using the full system.



Tech Tip:

Combine with 3M™ Pneumatic Angle Grinder and 3M™ Disc Back-up Pad or Scotch-Brite™ Universal Back-up Pad and set yourself up to a new level of productivity. Each component of this system has been engineered to optimize abrasive life, cut rate and consistency—helping to improve productivity and lower overall costs.

1. Testing completed internally at 3M with 4.5 inch discs to measure cut (g/min) per cycle. 3M Optimized System includes a 13A Tool, paired with 1182C and 3M™ Red Extra Hard Ribbed Back-up Plate. 3M™ Red Extra Hard Ribbed Back-up Plate tested with an 11A tool and 1182C, 36+ disc. Fibre Disc 1182C tested with 11A Tool and Gray Back-up Pad. Un-optimized System was tested with an 11A tool, Crushed Ceramic Competitor fibre disc and Gray Back-up Pad.



3M™ Cubitron™ 3 Performance Abrasives

Products on pages 4–5

Scotch-Brite™ Nonwoven Abrasives

Products on pages 6–7

3M™ Pneumatic Angle Grinder

3M™ Electric Grinder

3M™ Disc Back-up Pad, Ribbed, Extra Hard

Scotch-Brite™ Universal Back-up Pad

System Advantage

Scan for more detailed product ordering info

3M Abrasives Customer Story

> *“We quickly realized we couldn’t afford to use anything else but Cubitron™ 3.”*

Graham Hanks, Production Manager at Reddish Electroplating

The Challenge

Graham Hanks, Production Manager, needed to find a faster way of removing the topcoat, machine marks, and welds down to sound metal before the chrome plating and subsequent finishing steps could be completed. The substrate they use are particularly hard to grind fast with speed and consistency.

The Solution

With support from a 3M Process Specialist, Graham oversaw a trial of 3M™ Cubitron™ 3 Fibre Discs on the 3M™ 1900W Angle Grinder and 3M™ Cubitron™ 3 Cloth Belts on his existing portable belt machines. The patented grain technology meant that even on these hard to grind substrates, the work got done faster and the scratch pattern left behind was more than good enough to chrome plate and polish to the desired finish specification.

Here’s what Graham had to say:
“Tom is one of our most experienced metalworkers and his feedback was critical in our assessment of the trial. Once we saw the significant increase in through-put these products are capable of delivering, without compromising on our commitment to quality, we quickly realized we couldn’t afford to use anything else but Cubitron™ 3. We now get twice the work done in half the time and the products are lasting at least twice as long. Cubitron™ 3 has transformed our process and supports our commitment to quality work.”



Tom Gibson, Experienced Metalworker at Reddish Electroplating

SEAM™
Sustainable European Abrasive Manufacturers

Sustainability matters to 3M Abrasives.

When you buy from the SEAM value chain, you are helping to build a sustainable future for our industry, for people and for the planet. 3M is a founding member of the SEAM abrasives manufacturers program and aligns to the world’s highest standards of quality, safety and performance in a sustainable environment. We commit to transparency, accountability, innovation and progress. When buying from the SEAM value chain, customers are helping to build themselves a sustainable future.

Find out more at www.seam.earth

1. **Performance testing in a typical weld preparation process;** 3M™ Cubitron™ 3 Fibre Disc 1182C, 36+ average compared to the average result of 10 globally selected high-quality competitive type 27 grinding wheels including ceramic grain products, according to independent testing by Fraunhofer Institute. January 2024.
2. The ‘total material removed’ claim is determined by averaging the amount of metal ground over the entire test method (30 cycles or 30 minutes of grinding). Error bars represent the results with a 95% confidence level.
3. **Performance testing in a typical weld preparation process;** 3M™ Cubitron™ 3 Fibre disc average compared to the average result of 10 globally selected high-quality competitive type 27 Grinding wheels including ceramic grain products, according to independent testing by Fraunhofer Institute. January 2024.
4. **Noise energy operator exposure testing in a typical weld preparation process;** Cubitron™ 3 Fibre disc average compared to the average result of 10 globally selected high-quality competitive type 27 Grinding wheels including ceramic grain products, according to independent testing by Fraunhofer Institute. January 2024.
5. Results are based on an automated, 37.5 minute, medium pressure test on 1045 steel using 4.5 inch 40 grit flap discs on a servo motor.
6. Results are based on an automated, cutting of a 3 mm thick 304 stainless steel sheet. Cut-off wheel geometry was T41 125 mm x 1.6 mm x 22 mm mounted on a 1.5 hp angle grinder with an applied force of 9 lbs. Cut speed was defined by time needed to cut 1 meter of stainless steel. The number of cuts was estimated by the amount of wheel that was used after cutting a distance of 1 meter. End of life is assumed to be 50% of initial wheel mass.
7. Performance testing in a typical weld preparation process or cutting operation; 3M™ Cubitron™ 3 Cut-Off Wheels average compared to the average results of the high-quality competitive ceramic grain competitive wheels tested, according to independent testing, August 2023.
8. Results are based on an automated beveling of 1018 carbon steel bars. Grinding wheel geometry was 115 mm outer diameter mounted on a servo motor with an applied force of 12 lbs. Cut speed was defined by metal removed after 10 minutes of testing life. End of life is assumed to be 50% of the initial wheel mass.
9. Performance testing in a typical weld preparation process or cutting operation; 3M™ Cubitron™ 3 Depressed Center Grinding Wheels average compared to the average results of the high-quality competitive ceramic grain competitive wheels tested, according to independent testing, August 2023.
10. Results are based on an automated beveling of 1018 carbon steel bars. Grinding wheel geometry was 115 mm outer diameter mounted on a servo motor with an applied force of 12 lb. Cut speed was defined by metal removed after 10 minutes of testing. The total material removal was estimated based on the amount of wheel that was used for 10 minutes of testing life. End of life is assumed to be 50% of the initial wheel mass.
11. Based on 3M Internal Testing: CRS 3" discs were tested robotically on 304 series stainless steel for 12 minutes, using a 3" 3M™ Hard Back-Up, part number: 45091. One part is equivalent to 20 g of material removed.
12. Based on 3M internal testing: MED 3" discs were tested robotically on 6061 aluminum until the end of life (end of life is determined to be 50% of the averaged cut rate of the first three minutes) using a 3" 3M™ Hard Back-Up, part number: 45091. One part is equivalent to 20 g of material removed.
13. Hand-arm vibration compared to listed competitor and Scotch-Brite™ Clean and Strip XT Pro Disc, Type 27, according to independent testing by Fraunhofer Institute on October 2021.

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