

Abrasive Belt Systems



3M™ Belts

3M is the one-stop shop for all of your abrasive metalworking belt needs! We offer a product tailored to nearly every application and performance level. To select the best product for your application, check out our easy-to-use Belt Selection Guide. Each tier of product offers best-in-class performance at various price points. Once you have selected the product, use the Availability Guide to select your grade. The following section includes our most popular belt items, but remember, we can provide any size belt that you might need!

Abrasive Speed Recommendations for Off-Hand Applications

Alloy	Belt Speed (surface feet per minute)	Applicable Belt Grades
Cast Iron	7,000	24–120
Carbon Steel	6,500	24–120
Stainless Steel	6,500–7,000	36–120
Nickel Alloys	6,000	36–120
Titanium	2,500–3,000	36–180
Aluminum	7,500–8,500	24–120
Aluminum	6,500–7,000	Fine Grades
Brass	7,000–8,000	36–180
Rubber	4,500	36–180
Glass	2,500–5,000	80–400
Glass	6,000–8,000	80–400
Stone	7,000	36–180

3M™ Coated Abrasive Belt Availability Guide

Key ● = Available grade **P** = FEPA (P-grade) **+** = 3M precision shaped grain

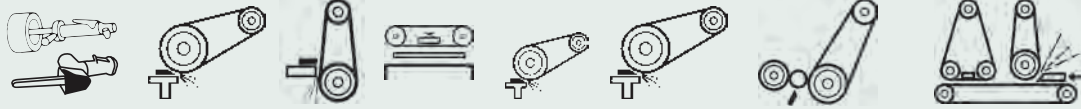
3M ID	Mineral	Backing	Grinding Aid	Use Dry/Wet	600	500	400	320	240	220	180	150	120	100	80	60	50	40	36	24
241E	Aluminum Oxide	XE		Dry				P		P	P	P	P	P	●					
302D		J		Dry	P	P	P	P	P	P	P	P	P	P	●	●				
332D		Flex X		Dry			P	P	P	P	P	P	P	P	●	●				
341D		X		Dry			P	P	P	P	P	P	P	P	●	●	●	●	●	●
361F		XF		Dry/Wet			P	P	P	P	P	P	P	P	●	●	●	●	●	●
461F	Silicon Carbide	XF		Dry/Wet	P		P	P	P	P	P	P	P	P	P	P		P	P	
577F	Alumina Zirconia	YF	Yes	Dry/Wet							●	●	●	●	●	●	●	●	●	●
747D	Ceramic A/O* Blend	X	Yes	Dry								P	P	P	●	●	●		●	
777F		YF	Yes	Dry/Wet							P	P	P	P	●	●	●	●	●	
947A	Precision Shaped Ceramic and A/O* Blend	X	Yes	Dry/Wet									+		+	+		+		
963G	Ceramic	YN		Dry/Wet									●	●	●	●	●	●	●	●
966F		YF		Dry/Wet											●	●	●	●	●	●
977F		YF	Yes	Dry/Wet									●	●	●	●	●	●	●	●
984F	Precision Shaped Ceramic	YF	Yes	Dry/Wet											+	+			+	
994F		ZF		Dry/Wet																+
997F		ZF	Yes	Dry/Wet																

*A/O – Aluminum Oxide

How to Use the Coated Abrasive Belt Selection Guide

1. Find the machine type that you will run this belt on.
2. Move down to the metal type that is being worked on.
3. Select the product from the list of **Good** — **Better** — **Best** and **Finishing** belts.
4. Check the Availability Guide for the grade.
5. Find the product on the following pages for available sizes.
6. If your size is not listed, contact your 3M distributor or 3M representative for ordering instructions.

3M™ Coated Abrasive Belt Selection Guide



Performance	Portable/ File Tool	Coarse Grade Power Grinding/ High Pressure	Slack of Belt Sander	Stroke Sander	Bench Top Belt Machine	Backstand/ Off Hand	Centerless & Roll Grinding		Flat Finishing	
							Dry	Wet	Dry	Wet
Carbon Steel										
Good	241E	577F	341D	—	341D	341D	—	—	341D	361F
Better	577F	963G	577F	—	577F	577F	577F	577F	577F	577F
Best	984F/947A	984F/994F/997F	947A	—	984F/947A	984F/947A	966F	966F	966F	966F
Finishing	—	—	341D/ Trizact*	—	341D/ Trizact*	3XXD**/ Trizact*	777F/ Trizact*	Trizact*	461F	461F
Stainless Steel										
Good	—	—	577F	341D	577F	577F	—	—	341D	361F
Better	577F	577F	777F	—	777F	777F	577F	577F	577F	577F
Best	984F/947A	984F/994F/997F	947A	747D/ 947A	984F/947A	984F/947A	977F	966F	984F	984F
Finishing	—	—	Trizact*	—	Trizact*	3XXD**/ Trizact*	777F/ Trizact*	Trizact*	461F/ Trizact*	461F/ Trizact*
Aluminum, Brass, Bronze										
Good	241E	577F	—	—	—	—	—	—	341D	361F
Better	577F	963G	577F	—	577F	577F	577F	577F	577F	577F
Best	984F/947A	984F/994F/997F	947A	—	984F/947A	984F/947A	—	—	—	—
Finishing	—	—	341D/ Trizact*	—	341D/ Trizact*	3XXD**/ Trizact*	341D/ Trizact*	461F	461F	461F
Cobalt and Nickel Alloys										
Good	—	—	577F	—	577F	577F	—	—	577F	577F
Better	577F	577F	777F	—	777F	777F	577F	577F	777F	777F
Best	984F/947A	984F/994F/997F	947A	—	984F/947A	984F/947A	977F	966F	984F	984F
Finishing	—	—	Trizact*	—	Trizact*	3XXD**/ Trizact*	777F/ Trizact*	Trizact*	461F	461F
Titanium										
Good	—	—	461F	—	461F	461F	—	—	—	461F
Better	577F	577F	577F	—	577F	577F	—	577F	—	577F
Best	984F	984F/994F/997F	—	—	984F	984F	—	966F	—	966F
Finishing	—	—	461F/Trizact*	—	461F/ Trizact*	3XXD**/ Trizact*	—	Trizact*	—	461F

*For specific Trizact product recommendations, see page 47.

**3XXD: Choose from 302D, 332D and 341D depending upon backing flexibility needed for application.

Note

For the ultimate in performance for coarse grade grinding in any application, be sure to try the latest innovation: 3M™ Cubitron™ II Metalworking Belts.

3M™ Belts

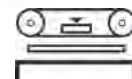
577F (cont.)

UPC	W x L	Grade	Qty./Case
051111-67602-8	2" x 132"	36	25/50
051141-30702-2	2" x 132"	50	25/50
051111-69105-2	2" x 132"	60	25/50
051111-69108-3	2" x 132"	80	25/50
051141-30696-4	2" x 132"	120	25/50
051119-64999-4	2-1/2" x 60"	36	25/50
051111-69106-9	2-1/2" x 60"	60	25/50
051125-12707-3	2-1/2" x 60"	80	25/50
051141-30706-0	2-1/2" x 60"	120	25/50
051111-69099-4	3" x 132"	36	25/50
051119-82066-9	3" x 132"	50	25/50
051111-69569-2	3" x 132"	60	25/50
051111-69571-5	3" x 132"	80	25/50
051111-67681-3	3" x 132"	120	25/50
051119-67701-0†	3-1/2" x 15-1/2"	60	50
051119-58968-9†	3-1/2" x 15-1/2"	80	50
051119-67700-3†	3-1/2" x 15-1/2"	120	50
051111-67604-2	4" x 132"	36	25
051115-27562-3	4" x 132"	50	25
051111-69570-8	4" x 132"	60	25
051111-69573-9	4" x 132"	80	25
051125-23987-5	4" x 132"	120	25
051111-69445-9	6" x 48"	60	20
051119-83855-8	6" x 48"	80	20
051141-30707-7	6" x 48"	120	20
051111-69440-4	37" x 60"	36	2
051111-68691-1	37" x 60"	60	2
051111-69111-3	37" x 60"	80	2
051111-69115-1	37" x 60"	120	5
051125-22740-7	37" x 60"	180	5
051119-61101-4	37" x 75"	36	2
051111-68692-8	37" x 75"	60	2
051111-69112-0	37" x 75"	80	2
051111-67688-2	37" x 75"	120	5
051125-09283-8	37" x 75"	180	5

† Made-to-Order

747D

- 3M ceramic aluminum oxide blend abrasive grain on an X wt. cloth backing
- Use for offhand heat sensitive stainless steel applications
- Grinding aid enhances performance on stainless steel and other exotic alloys
- Well suited for stroke sanding applications

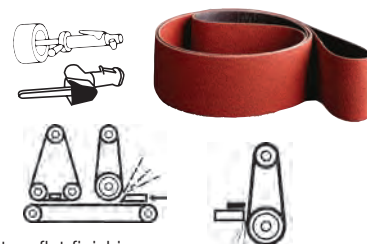


UPC	W x L	Grade	Qty./Case
051111-67749-0†	3" x 9-1/2"	50	200
051111-67759-9†	3" x 9-1/2"	60	200
051111-67789-6†	3" x 9-1/2"	P100	200
051111-67806-0†	3" x 9-1/2"	P120	200
051111-67807-7†	3" x 118"	P120	50
051115-27355-1†	3" x 132"	60	50
051111-68923-3†	3" x 132"	P120	50
051111-67751-3†	6" x 264"	50	10
051111-67766-7†	6" x 264"	60	10
051111-67778-0†	6" x 264"	80	20
051125-20535-1†	6" x 264"	P100	20
051111-67812-1†	6" x 264"	P120	20
051144-85846-0†	6" x 274"	60	20
051111-67779-7†	6" x 274"	80	20
051111-67767-4†	6" x 300"	60	10
051111-67781-0†	6" x 300"	80	20
051111-67813-8†	6" x 300"	P120	20
051115-19560-0†	6" x 355"	50	10
051111-67755-1†	6" x 360"	50	10

† Made-to-Order

777F

- 3M ceramic aluminum oxide blend abrasive grain on a YF wt. cloth backing
- Contains grinding aid which enhances performance on stainless steel and other exotic alloys
- For use on backstand, benchtop, flat finishing, slack of belt, centerless and dry roll grinding equipment
- Can be run wet or dry



UPC	W x L	Grade	Qty./Case
051144-84403-6	1/4" x 18"	60	200
051144-85318-2	1/4" x 18"	80	200
051144-19579-2	1/4" x 18"	P120	200
051144-84412-8	1/4" x 24"	40	200
051144-80253-1	1/4" x 24"	60	200
051144-77642-9	1/4" x 24"	80	200
051144-82229-4	1/4" x 24"	P120	200
051111-69457-2	1/2" x 12"	60	200
051144-85372-4	1/2" x 12"	80	200
051111-69604-0	1/2" x 12"	P120	200

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777F (cont.)

UPC	W x L	Grade	Qty./Case
051144-84301-5	1/2" x 18"	36	200
051144-84409-8	1/2" x 18"	40	200
051144-80551-8	1/2" x 18"	60	200
051144-80232-6	1/2" x 18"	80	200
051144-84304-6	1/2" x 18"	P120	200
051144-77643-6	1/2" x 24"	36	200
051144-82342-0	1/2" x 24"	40	200
051144-77408-1	1/2" x 24"	50	200
051144-77065-6	1/2" x 24"	60	200
051144-77491-3	1/2" x 24"	80	200
051144-81064-2	1/2" x 24"	P120	200
051144-84302-2	3/4" x 18"	36	200
051144-84404-3	3/4" x 18"	60	200
051144-77992-5	3/4" x 18"	80	200
051144-84303-9	3/4" x 18"	P120	200
051144-80486-3	3/4" x 20-1/2"	60	200
051144-80686-7	3/4" x 20-1/2"	80	200
051125-23897-7	1" x 18"	60	200
051144-85319-9	1" x 18"	80	200
051141-30705-3	1" x 18"	P120	200
051144-76527-0	1" x 42"	40	50/200
051144-77512-5	1" x 42"	60	50/200
051144-14895-0	1" x 42"	80	50/200
051144-84416-6	1-1/2" x 60"	60	25/50
051144-76731-1	1-1/2" x 60"	80	25/50
051144-82022-1	1-1/2" x 60"	P120	25/50
051144-76738-0	2" x 48"	36	10/50
051144-76519-5	2" x 48"	60	25/50
051144-14896-7	2" x 48"	80	25/50
051144-85393-9	2" x 48"	P120	50
051144-77663-4	2" x 60"	36	50
051144-77152-3	2" x 60"	60	50
051144-84296-4	2" x 60"	80	50
051144-85377-9	2" x 60"	P120	50
051144-76531-7	2" x 72"	36	50
051144-80286-9	2" x 72"	60	50
051144-14884-4	2" x 72"	80	50
051144-81767-2	2" x 72"	P120	50
051144-14264-4	2" x 132"	36	50
051144-14899-8	2" x 132"	50	50
051144-82231-7	2" x 132"	60	50
051144-14534-8	2" x 132"	80	50
051144-81687-3	2" x 132"	P120	50
051144-84315-2	2" x 132"	P180	50
051144-76532-4	2-1/2" x 60"	36	50
051144-77825-6	2-1/2" x 60"	40	50
051144-76680-2	2-1/2" x 60"	60	50
051144-76686-4	2-1/2" x 60"	80	50
051115-27389-6	2-1/2" x 60"	P120	50

777F (cont.)

UPC	W x L	Grade	Qty./Case
051144-76533-1	3" x 132"	36	25
051111-69455-8	3" x 132"	50	25
051144-76520-1	3" x 132"	60	25
051144-76514-0	3" x 132"	80	25
051144-80028-5	3" x 132"	P120	50
051144-85762-3	3" x 132"	P180	50
051144-77336-7	3-1/2" x 15-1/2"	36	50
051144-77334-3	3-1/2" x 15-1/2"	50	50
051144-77476-0	3-1/2" x 15-1/2"	60	50
051144-77333-6	3-1/2" x 15-1/2"	80	50
051144-84306-0	3-1/2" x 15-1/2"	100	50
051144-84307-7	3-1/2" x 15-1/2"	P120	50
051144-85320-5	3-1/2" x 15-1/2"	P180	50
051144-76534-8	4" x 132"	36	25
051111-67851-0	4" x 132"	50	25
051144-80707-9	4" x 132"	60	25
051144-76515-7	4" x 132"	80	25/50
051141-30700-8	4" x 132"	P120	25
051144-82313-0	6" x 48"	36	10/20
051144-80176-3	6" x 48"	50	10/20
051144-76679-6	6" x 48"	60	20
051144-76733-5	6" x 48"	80	20
051144-82153-2	6" x 48"	P120	20
051125-33828-8	37" x 60"	36	2
051115-27354-4	37" x 60"	60	2
051144-77351-0	37" x 60"	80	2
051144-80450-4	37" x 60"	P120	5
051111-69127-4	37" x 60"	P180	5
051119-75481-0	37" x 75"	36	2
051111-69122-9	37" x 75"	60	2
051144-82930-9	37" x 75"	80	2
051144-84947-5	37" x 75"	P120	5
051111-69128-1	37" x 75"	P180	5