



3M Science.
Applied to Life.™

Scotch-Brite™ Surface Conditioning
Wheels Selection Guide

**Easy does it for deburring
finishing, blending
cleaning & more!**

Wheel Selection in 3 Easy Steps

Step 1

Select the type of wheel that will work with your equipment.

Convolute wheels are typically bigger and used on stationary equipment.

Unitized wheels are generally smaller wheels used on portable tools.

Step 2

What are you trying to do with the wheel?

There are two main applications for surface conditioning wheels: deburring and finishing. If you are deburring parts or radiusing edges, use a deburring wheel (see pg. 4 for convolute, pg. 6 for unitized). To create an aesthetic finish, use an appropriate finishing wheel (see pg. 5).

If your part requires both deburring and aesthetic finishing, start with a deburring wheel. If necessary, follow up with a finishing wheel to create the required finish.

Step 3

Use the next 4 pages to select your wheel.

Wheel descriptions include many pieces of relevant information, from wheel composition to size.

Use this key to read Scotch-Brite wheel descriptions:

| 9 | S | FIN | 8" | x | 1" | x | 3" |
|---------|---------|-------|----------|---|-------|---|------|
| Density | Mineral | Grade | Diameter | | Width | | Core |

Getting Started

For over 50 years, 3M has made your toughest jobs easier with a broad portfolio of surface conditioning wheels. Now, we're making it even easier to choose the best option for your application – from aesthetic finishing to weld blending, deburring and more!

Convolute Wheels

Scotch-Brite™ EXL PRO

| UPC (051125) | Grade | Max RPM | Size |
|-----------------|---------|------------|--------------|
| 94904-5 | 9S FIN | 6,000 | 6 × 1/2 × 1" |
| 94926-7 | 10S FIN | | 6 × 1 × 1" |
| 94905-2 | 9S FIN | | 6 × 1 × 1" |
| 94917-0 | 10S FIN | | 6 × 1 × 1" |
| 94907-1 | 9S FIN | 4,500 | 8 × 1/2 × 3" |
| 94927-4 | 10S FIN | | 8 × 1/2 × 3" |
| 94908-8 | 9S FIN | | 8 × 1 × 3" |
| 94918-7 | 10S FIN | | 8 × 1 × 3" |
| 94913-2 | 9S FIN | 3,000 | 12 × 1 × 5" |
| 94902-6 | 10S FIN | | 12 × 1 × 5" |
| 94914-9 | 9S FIN | | 12 × 2 × 5" |

3M™ General Deburring Wheels

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|------------|--------------|
| 64899-6 | 9S FIN | 6,000 | 6 × 1/2 × 1" |
| 64900-9 | 9S FIN | | 6 × 1 × 1" |
| 64901-6 | 9S FIN | 4,500 | 6 × 1/2 × 1" |
| 64902-3 | 9S FIN | | 8 × 1 × 3" |

Scotch-Brite™ EXL Deburring Wheels

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|------------|--------------|
| 13616-5 | 8A MED | 6,000 | 6 × 1/2 × 1" |
| 09548-6 | 8S FIN | | 6 × 1/2 × 1" |
| 05790-3 | 9S FIN | | 6 × 1/2 × 1" |
| 13617-2 | 8A MED | | 6 × 1/2 × 1" |
| 09549-3 | 8S FIN | 4,500 | 6 × 1 × 1" |
| 05132-1 | 9S FIN | | 6 × 1 × 1" |
| 17459-4 | 8A MED | | 6 × 1 × 1" |
| 14629-4 | 8S FIN | | 6 × 1 × 1" |
| 05791-0 | 9S FIN | 4,500 | 8 × 1/2 × 3" |
| 13619-6 | 8A MED | | 8 × 1/2 × 3" |
| 09551-6 | 8S FIN | | 8 × 1/2 × 3" |
| 05135-2 | 9S FIN | | 8 × 1/2 × 3" |
| 13620-2 | 8A MED | 4,500 | 8 × 1 × 3" |
| 09552-3 | 8S FIN | | 8 × 1 × 3" |
| 05136-9 | 9S FIN | 4,500 | 8 × 2 × 3" |

Scotch-Brite™ Metal Finishing Wheels

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|---------|------------|
| 01862-1 | 5A MED | 6,000 | 6 × 1 × 1" |
| 01863-8 | 5A CRS | | 6 × 1 × 1" |
| 01869-0 | 5A MED | | 6 × 2 × 1" |
| 01888-1 | 5A CRS | | 6 × 2 × 1" |
| 01871-3 | 5A MED | 4,500 | 8 × 1 × 3" |
| 01872-0 | 5A CRS | | 8 × 1 × 3" |
| 01876-8 | 5A MED | | 8 × 2 × 3" |
| 01904-8 | 5A CRS | | 8 × 2 × 3" |

Scotch-Brite™ Multi-Finish Wheels

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|---------|------------|
| 13170-2 | 2S CRS | 6,000 | 6 × 1 × 1" |
| 13171-9 | 2S MED | | 6 × 1 × 1" |
| 13172-6 | 2S FIN | | 6 × 2 × 1" |
| 13176-4 | 2S CRS | | 6 × 2 × 1" |
| 13177-1 | 2S MED | 4,500 | 8 × 1 × 3" |
| 13178-8 | 2S FIN | | 8 × 1 × 3" |
| 13183-2 | 2S MED | | 8 × 2 × 3" |
| 13184-9 | 2S FIN | | 8 × 2 × 3" |
| 13185-6 | 2S CRS | 4,500 | 8 × 2 × 3" |
| 13186-3 | 2S MED | | 8 × 2 × 3" |

*Most
Popular
Products*

Unitized Wheels

Scotch-Brite™ Rapid Cut Unitized Wheels

| UPC (051115) | Density | Grade | Max RPM | Size |
|-----------------|---------|-------|------------|----------------|
| 66699-5 | 7 | CRS+ | 35,100 | 1 × 1 × 3/16" |
| 66725-1 | 7 | XCS+ | | 3 × 1/4 × 3/8" |
| 66722-0 | 9 | CRS+ | 18,100 | 3 × 1/4 × 3/8" |
| 66748-0 | 9 | XCS+ | | 3 × 1/4 × 3/8" |
| 66704-6 | 7 | CRS+ | 12,100 | 4 × 1/4 × 5/8" |
| 66730-5 | 7 | XCS+ | | 4 × 1/4 × 5/8" |
| 66721-3 | 9 | CRS+ | | 4 × 1/4 × 5/8" |
| 66747-3 | 9 | XCS+ | | 4 × 1/4 × 5/8" |

Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheels

| UPC | Density | Grade | Max RPM | Size |
|----------------|---------|-------|------------|---------|
| 051115-66759-6 | 9 | CRS+ | 22,100 | 2" × NH |
| 048011-64859-0 | 9 | CRS+ | 15,100 | 3" × NH |
| 051115-66760-2 | 9 | XCS+ | 15,100 | 3" × NH |

Scotch-Brite™ EXL Unitized Wheel

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|------------|----------------|
| 15527-2 | 2A MED | 25,100 | 1 × 1 × 3/16" |
| 13713-1 | 2S FIN | 30,100 | |
| 14063-6 | 6A MED | 35,100 | |
| 13753-7 | 8A MED | | |
| 13752-0 | 8A CRS | | |
| 16054-2 | 2A MED | 12,100 | 3 × 1/4 × 3/8" |
| 14750-5 | 2S FIN | | |
| 15118-2 | 6A MED | 18,100 | |
| 14753-6 | 8A MED | | |
| 13766-7 | 8A CRS | | |

Scotch-Brite™ Roloc™ EXL Unitized Wheels

| UPC (048011) | Grade | Max RPM | Size |
|-----------------|--------|------------|---------|
| 17185-2 | 2A MED | 22,100 | 2" × NH |
| 17183-8 | 2S FIN | | |
| 17190-6 | 6A MED | | |
| 17192-0 | 8A MED | | |
| 17186-9 | 2A MED | 15,100 | 3" × NH |
| 17184-5 | 2S FIN | | |
| 17191-3 | 6A MED | | |
| 17193-7 | 8A MED | | |

Deburring^{with} Convolute Wheels

Scotch-Brite Deburring Wheels are typically used for removing the metal burrs left by fabrication activities. They are also used for radiusing sharp edges, cleaning and light blending.

3M General Deburring

- General purpose
- Single packaging
- Value pricing

Scotch-Brite™ EXL

- Improved consistency
- Versatile and broad product line
- Trusted performance

Scotch-Brite™ EXL PRO

- Longest life without sacrificing feel or conformability
- Extra cut without sacrificing finish
- Ideal in off-hand applications

Performance ↑

NEW!

Scotch-Brite™ EXL PRO

The new EXL PRO Deburring Wheel was designed with the operator in mind. It provides longer life and extra cut, but is not too hard and does not finish too coarse. It runs smoothly and requires less pressure to get the job done. For operators who can feel the difference, this is the wheel of choice.

| Density | Mineral | Grade | Diameter | Width |
|---------|---------|-------|----------|---------|
| 9 & 10 | S/C | FIN | 4 – 24" | ½ – 42" |

↑
Ideal
starting
point

High Performance

- 30–50% longer life than original EXL
- More total cut – with less operator pressure
- Soft and smooth
- Operator friendly

Scotch-Brite™ EXL, EX2 & EX3 Deburring Wheels

The original EXL, EX2 and EX3 Deburring Wheels offer good value and the most versatile product portfolio. For years these wheels have provided customers with an easy solution for deburring, radiusing and blending their metal parts. This line provides versatility and consistent performance.

| Density | Mineral | Grade | Diameter | Width |
|------------|-----------|-----------|----------|---------|
| EXL (Soft) | A/O & S/C | FIN & MED | 4 – 24" | ½ – 42" |
| EX2 (Med) | | | | |
| EX3 (Hard) | | | | |

Good Performance

- Broad range of products and sizes (many stocked items)
- Consistent performance

3M™ General Deburring Wheel

This General Deburring Wheel provides basic performance at competitive prices and order quantities. This wheel provides the performance required for light to medium deburring applications, as well as for cleaning and finishing applications.

| Density | Mineral | Grade | Diameter | Width |
|---------|---------|-------|----------|--------|
| 9 | S/C | FIN | 6 & 8" | ½ & 1" |

Basic Use

- Single package quantities
- Strong overall value
- Value priced



Finishing with Convolute Wheels

Introducing the
"Finishing Four."
The easiest
way to achieve
the look you're
going for!

These wheels are primarily used for producing various aesthetic finishes on metal. Each wheel creates a different finish, as described below.

| Width | 3/8 - 42" | | | | | | | | | |
|-----------|-----------|---|---|----|----|----|----|----|----|--|
| Core Size | 1 | 1 | 3 | 5 | 5 | 8 | 10 | 12 | 12 | |
| Diameter | 4 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 24 | |



Scotch-Brite™ Light Deburring Wheels

Produces a bright and consistent finish with a tight scratch pattern. These very soft, conformable wheels can be used for finishing and light deburring.

| Density | Mineral | Grade | Diameter | Width |
|----------|---------|-------|----------|---------|
| 6, 7 & 8 | S/C | FIN | 4-24" | 1/2-42" |



Scotch-Brite™ Cut and Polish Wheels

Produces a dull finish with a tight scratch pattern. This denser, harder wheel can be used for aggressive finishing applications, and is good for defect removal and scratch blending.

| Density | Mineral | Grade | Diameter | Width |
|---------|-----------|----------------|----------|---------|
| 5 & 7 | A/O & S/C | FIN, MED & CRS | 4-24" | 1/2-42" |



Scotch-Brite™ Multi-Finishing Wheels

For creating a bright finish with a wide scratch pattern. This multi-purpose wheel is often used on inline sanding tools for large surface repair.

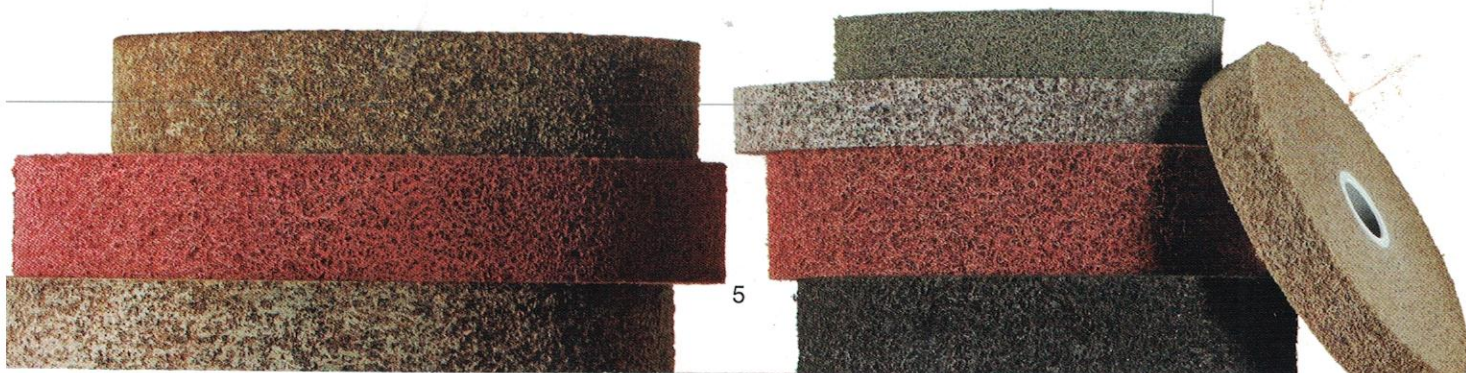
| Density | Mineral | Grade | Diameter | Width |
|----------|---------|----------------|----------|---------|
| 2, 3 & 4 | S/C | FIN, MED & CRS | 4-24" | 1/2-42" |



Scotch-Brite™ Metal Finishing Wheels

Creates a satin finish that is somewhat coarser and duller than our Light Deburring Wheels.

| Density | Mineral | Grade | Diameter | Width |
|----------|---------|-----------|----------|---------|
| 4, 5 & 6 | A/O | MED & CRS | 4-24" | 1/2-42" |



Deburring, Blending & Finishing with Unitized Wheels

Unitized wheels are typically smaller for use with portable tools, and are perfect for a variety of applications. The EXL product line offers the most versatile range of products, starting from a soft 2 density (great for delicate and intricate work) to a hard 8 density (for durability in deburring applications).

Scotch-Brite™ EXL Unitized Wheels

| Density | Mineral | Grade | Diameter | Width |
|-------------|-----------|-------------------------|----------|-------|
| 2, 4, 6 & 8 | A/O & S/C | VFN, FIN, MED, CRS, XCS | ½-14" | ⅛-1" |

Broadest Offering

- Long lasting
- Smear resistant
- Outstanding consistency
- Available with center hole or 3M™ Roloc™ attachment

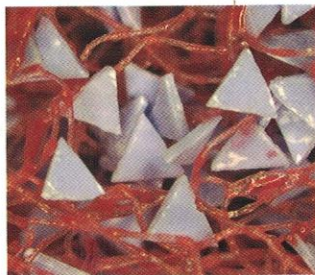


Scotch-Brite™ EXL Roloc™ Unitized Wheels

| Density | Mineral | Grade | Diameter | Width |
|-------------|-----------|--------------------|----------|-------|
| 2, 4, 6 & 8 | A/O & S/C | FIN, MED, CRS, XCS | 2 & 3" | ⅛-¼" |



Heavy Deburring & Weld Blending with Unitized Wheels



Scotch-Brite™ Rapid Cut Wheels combine the proven nonwoven abrasive technology used in all our Scotch-Brite products with 3M's proprietary precision-shaped grain. Now you can get everything you love about Scotch-Brite abrasives – including consistent finishes and ease of use – with up to 3 times higher cut rates than the leading competitive wheels. Makes tough jobs like weld blending and heavy deburring fast and easy!

Scotch-Brite™ Rapid Cut Unitized Wheels

| Density | Mineral | Grade | Diameter | Width |
|---------|--------------------------------|---------------|----------|-------|
| 7* & 9 | Ceramic Precision Shaped Grain | CRS+ and XCS+ | 1-14" | ⅛-1" |

*7 density not available in 3" diameter

Fast Cutting

- High cut rate
- Long life
- Helps improve productivity

Scotch-Brite™ Roloc™ Rapid Cut Unitized Wheels

| Density | Mineral | Grade | Diameter | Width |
|---------|--------------------------------|---------------|----------|-------|
| 9 | Ceramic Precision Shaped Grain | CRS+ and XCS+ | 2 & 3" | ⅛-¼" |



Tools & Accessories

These are just a few of the many specialized tools and accessories optimized for use with Scotch-Brite™ Abrasives. For product recommendations on your specific application, contact your Authorized 3M Abrasives Distributor or 3M Representative.

Recommended Tools

3M™ Die Grinders, 1 HP (744W)

| Model No. | Weight lbs. (kg) | Length inch (mm) | Air Inlet Thread inch | Collet Size inch | Max RPM | UPC |
|-----------|------------------|------------------|-----------------------|------------------|---------|----------------|
| 20238 | 1.69 (0.77) | 7.75 (196.9) | ¼ NPT | ¼ | 18,000 | 051141-20238-9 |
| 20239 | 2.06 (0.93) | 10 (254) | ¼ NPT | ¼ | 12,000 | 051141-20239-6 |
| 20240 | 2.06 (0.93) | 10 (254) | ¼ NPT | ¼ | 8,000 | 051141-20240-2 |

3M™ Grinders – Type 27, 1 HP (744W)

| Model No. | Tool Dia. inch (mm) | Length | Air Inlet Thread inch | Thread Size inch | Max RPM | UPC |
|-----------|---------------------|----------|-----------------------|------------------|---------|----------------|
| 28403 | 4 (100) | Standard | ¾ NPT* | ¾-24 EXT | 12,000 | 051141-29403-3 |
| 28413 | 4 (100) | Extended | ¾ NPT* | ¾-24 EXT | 12,000 | 051141-28413-2 |
| 28405 | 4 ½ (114.3) | Standard | ¾ NPT* | 5/8-11 EXT | 12,000 | 051141-28405-7 |
| 28414 | 4 ½ (114.3) | Extended | ¾ NPT* | 5/8-11 EXT | 12,000 | 051141-28414-9 |

*Includes ¾" to ¼" reducer

3M™ Inline Sanders 1 HP (744W)

Generate straight line scratches for finishing stainless steel and other metals. These straight shaft sanders can be used with inflatable or slotted wheel accessories and many other wheel products.

| Model No. | Weight lbs. (kg) | Length inch (mm) | Air Inlet Thread inch | Collet Size inch | Max RPM | UPC |
|-----------|------------------|------------------|-----------------------|------------------|---------|----------------|
| 28338 | 3.32 (1.51) | 9.88 (251) | ¼ NPT | 5/8-11 | 1,600 | 051141-28338-8 |
| 28339 | 2.64 (1.20) | 8.50 (216) | ¼ NPT | 5/8-11 | 3,500 | 051141-28339-5 |

Recommended Accessories

3M™ Unitized Wheel Mandrels

| Part No. | Description | Shank Size inch | Overall Length inch | Outside Flange Dia. inch | Max RPM | MOQ | UPC |
|----------|--|-----------------|---------------------|--------------------------|---------|-----|----------------|
| 936 | <ul style="list-style-type: none"> Use with wheels 1" diameter x 1" wide x 3/16" center hole Plastic mandrel self taps into wheel | ¼ | 2 1/16 | ¾ | 22,200 | 1 | 048011-04018-9 |
| 990 | <ul style="list-style-type: none"> Use with high speed or easy loading Unitized Wheels 2" to 3" diameter x 1/8" to 1/2" wide x 3/8" center hole Includes silver cap for 1/8" and 1/4" wide wheels Includes black cap for 3/8" and 1/2" wide wheels | ¼ | 1 3/4 | 1 | 25,100 | 1 | 048011-15012-3 |

3M™ Flange Adapters

| Part No. | Description | Use With | UPC |
|----------|---|------------------|----------------|
| 16860-9 | 3M™ Flange Adapter #5, 1" wide telescoping wheel adapter. Reduce 1" I.D. core to 1/2", 5/8", 3/4", 7/8" | 1/2" wide wheels | 040811-16860-9 |
| 16859-3 | 3M™ Flange Adapter #5, 1/2" wide telescoping wheel adapter. Reduce 1" I.D. core to 1/2", 5/8", 3/4", 7/8" | 1/2" wide wheels | 040811-16859-3 |

3M™ Roloc™ Disc Pad TR Assembly

| Part No. | Description | Dia. inch | Thread Size inch | Color | Density Rating | Max RPM | MOQ | UPC |
|----------|---|-----------|------------------|-------|----------------|---------|-----|----------------|
| 05539 | Includes a 3M™ Roloc™ shank and adapter | 2 | ¼ - 20 INT | Black | Hard | 25,000 | 1 | 051144-05539-5 |
| 05540 | Includes a 3M™ Roloc™ shank and adapter | 3 | ¼ - 20 INT | Black | Hard | 20,000 | 1 | 051144-05540-1 |

Recommendations & Maximum Operating Speeds

Convolute Wheels

Maximum Operating Speeds (RPM)

| | Diameter (inch) | All Wheels (RPM) |
|------------------------------------|-----------------|------------------|
| Scotch-Brite™ EXL, | 4 | 9,000 |
| EX2, EX3, EXL PRO, | 6 | 6,000 |
| General Deburring, | 8 | 4,500 |
| Light Deburring, | 10 | 3,600 |
| Cut & Polish, Multi-Finish & Metal | 12 | 3,000 |
| Finishing Wheels | 14 | 2,550 |
| | 16 | 2,250 |
| | 18 | 2,000 |
| | 20 | 1,800 |
| | 24 | 1,500 |

This information is for summary purposes only. For detailed recommendations on a specific Scotch-Brite product, consult your Authorized 3M Abrasive Products Distributor or your local 3M representative.

Recommended Operating Speeds

| Application | Surface Feet Per Minute (SFPM) |
|---------------------------|--------------------------------|
| Decorative Finishing | 500-3000 |
| Composites/Soft Materials | 1200-2700 |
| Deburring | 5000-6500 |
| Blending/Polishing | 6000-8000 |

Unitized Wheels

Maximum Operating Speeds (RPM)

| Size (Diameter x Width) | CP-UW | EXL-UW 2S, 3S | EXL-UW 2A MED, 2A XCS, 4A XCS | EXL-UW 4, 6, 8 Except 4A XCS |
|----------------------------|--------|------------------|----------------------------------|---------------------------------------|
| Less than 1" | 40,100 | 35,100 | 30,100 | 40,100 |
| 1" x All | 35,100 | 30,100 | 25,100 | 35,100 |
| 1½" x All | 30,100 | 20,100 | 18,100 | 30,100 |
| 2 x ¼-½" | 22,100 | 16,100 | 16,100 | 22,100 |
| 2 x ¾-1" | 22,100 | 16,100 | 14,100 | 22,100 |
| 2½ x ⅛" | 20,100 | - | - | 20,100 |
| 2½ x ¼" | 20,100 | 14,100 | 14,100 | 20,100 |
| 2½ x ⅜" | 20,100 | 14,100 | 12,100 | 20,100 |
| 2½ x ½" | 18,100 | 14,100 | 12,100 | 18,100 |
| 2½ x ¾-1" | 18,100 | 12,500 | 10,000 | 18,100 |
| 3 x ⅛" | 18,100 | - | - | 18,100 |
| 3 x ¼" | 18,100 | 12,100 | 12,100 | 18,100 |
| 3 x ⅜" | 18,100 | 12,100 | 10,000 | 18,100 |
| 3 x ½" | 15,100 | 10,000 | 10,000 | 15,100 |
| 3 x ¾-1" | 15,100 | 10,000 | 9,000 | 15,100 |
| 4 x ⅛" | 12,100 | - | - | - |
| 4 x ¼-½" | 12,100 | 8,500 | 8,000 | 12,100 |
| 4 x ¾-1" | 12,100 | 8,000 | 7,000 | 12,100 |
| 5" x All | 9,000 | 6,000 | 5,500 | 9,000 |
| 6" x All | 7,500 | 5,000 | 4,500 | 7,500 |
| 7" x All | 6,000 | 4,500 | 4,000 | 6,000 |
| 8" x All | 5,500 | 4,000 | 3,500 | 5,500 |
| 9" x All | 5,000 | 3,500 | 3,000 | 5,000 |
| 10" x All | 4,500 | 3,200 | 2,800 | 4,500 |
| 11" x All | 4,000 | 2,900 | 2,500 | 4,000 |
| 12" x All | 3,750 | 2,600 | 2,300 | 3,750 |
| 13" x All | 3,450 | 2,400 | 2,100 | 3,450 |
| 14" x All | 3,200 | 2,200 | 2,000 | 3,200 |

Products with "Dual" Ratings & Higher Maximum Operating Speeds (MOS)

| Product Name | Density/ Grade | Size (Diameter x Width) | RPM |
|-----------------------------------|-------------------|----------------------------|--------|
| Clean and Strip Unitized Wheel | 7S XCS | 3" x ¼" | 18,100 |
| Cut and Polish Unitized Wheel | 5A FIN | 3 x ½" | 18,100 |
| | | 3 x ¾" | |
| | 7A MED | 3 x ½" | |
| | | 3 x ¾" | |
| | 7S MED | 3 x ½" | 22,100 |
| | | 3 x ¾" | |
| | 7A CRS | 3 x ½" | |
| | | 3 x ¾" | |
| EXL Unitized Wheel | 5A FIN | 2½ x ½" | 22,100 |
| | 7A MED | 2½ x ¾" | |
| | 7S MED | 2½ x ¼" | |
| | 7S MED | 2½ x ½" | |
| | 4A FIN | 3 x ½" | 18,100 |
| | 4S FIN | | |
| | 6A FIN | | |
| | 6S FIN | | |
| | 6A MED | | |
| | 8A MED | | |
| | 8A CRS | | |
| | 6A MED | 2½ x ½" | 20,100 |
| | 8A MED | | |

The Unitized Wheels listed above (in either ¼" or ⅜" I.D.) have been certified to run at higher maximum operating speeds when using the following hardware (or their equivalents): #990 or #991 Mandrel - or used with 1½" O.D. and ⅜" I.D. flat washers.

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