

## 3M™ Roloc™ Discs

3M™ Roloc™ Discs provide a fast, efficient method for grinding, blending, leveling and finishing on all types of metal. They lock securely in place with just a half twist...another half twist and they're off. Each disc is color coded by grade. (This does not include 3M Roloc TSM products.)

### 3M™ Roloc™ Disc Button Color/Grade Chart

- 24/Black
- 80/Yellow
- 150/Black
- 36/Brown
- 100/Blue
- 180/Brown
- 50/Green
- 120/White
- 240/Green
- 60/Orange

■ Mild Steel ■ Stainless Steel

Key: Colored square indicates recommended usage.

### 3M™ Roloc™ Cloth Disc Selection Guide

	Product ID	Mineral	Features	Metal Type	Grinding	Light Grinding	Blending	Deburring
Good	361F	Aluminum Oxide	General purpose grinding, light grinding, blending, and deburring on all metals	All Metals	●	●	●	●
	461F	Silicon Carbide	Ideal for grinding glass, titanium and non-ferrous metals	Titanium		●	●	●
Better	777F	Ceramic A/O* Blend	Durable Y wt. Cloth backing; Grinding aid	Stainless Steel, Nickel Alloy	●	●	●	●
Best	963G	Ceramic Abrasive Grain	Durable backing	Carbon Steel	●	●	●	●
	977F		Durable 2-ply backing; Grinding aid	Stainless Steel, Nickel Alloy	●	●	●	●

\*A/O – Aluminum Oxide

### 3M™ Roloc™ Fiber Disc Selection Guide


	Product ID	Mineral	Features	Metal Type	Grinding	Light Grinding	Blending	Deburring
Good	501C	Aluminum Zirconia	Versatile disc for use on a wide variety of metals; General purpose grinding, blending and finishing on all metals	All Metals	●	●		●
Better	785C	Ceramic A/O* Blend	Excellent for stainless steel; Grinding aid	Stainless Steel	●	●		●
Best	983C/988C	Ceramic Abrasive Grain	Fast cutting; Long life; Designed for a variety of carbon steel applications	Carbon Steel	●	●		●
	988R		Unique single-piece construction that can eliminate button delamination and enhance disc performance; Cut through metal stock to quickly level welds and take on tough jobs in small areas	Mild Steel	●	●		●

\*A/O – Aluminum Oxide


### 3M™ Roloc™ Attachment System Guide

Product ID	Attachment				Dia.	Attachment			
	TP	TR	TSM	TS		TP	TR	TSM	TS
361F	●	●	●		3/4"	●	●		●
461F		●			1"	●	●	●	●
777F		●	●	●	1-1/2"	●	●	●	●
963G		●			2"	●	●	●	●
977F		●			3"	●	●	●	●
501C		●	●		4"	●	●		●
785C		●							
983C/988C		●							
988R		●							


TP




TR



TSM



TS



### Optimum Tool Speeds to Maximize 3M™ Roloc™ Disc Cut Rates and Life

Disc Size	Material Type			
	Stainless	Aluminum	Steel	Titanium
1-1/2"	20,000 RPM	30,000 RPM	30,000 RPM	9,000 RPM
2"	15,000 RPM	20,000 RPM	20,000 RPM	7,000 RPM
3"	10,000 RPM	15,000 RPM	15,000 RPM	4,500 RPM
4"	8,000 RPM	9,000 RPM	9,000 RPM	3,000 RPM



See pages 72–77 for available accessories.

### 3M™ Roloc™ Discs (cont.)

#### 3M™ Roloc™ Disc 977F ■

- 3M™ Ceramic abrasive grain
- Features a grinding aid
- Excellent for stainless steel, titanium and high nickel alloys.




UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051144-83587-4	36	25,000	2"	50/200
051144-83588-1	60			
051144-83589-8	80			
051144-83590-4†	36	20,000	3"	
051144-83591-1	60			
051144-83592-8	80			
<b>Roloc TSM (Metal Button)</b> 				
051141-24005-3	36	30,000	1-1/2"	50/500
051141-24006-0	60			
051141-24003-9	36	25,000	2"	
051141-24004-6	60			

† Made-to-Order

#### 3M™ Roloc™ Fibre Disc 983C/988C ■

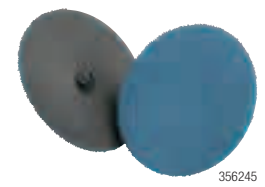
- 3M™ Ceramic abrasive grain content for fast cutting and long life
- Fibre backing for durability
- Designed for high-pressure weld leveling and deburring




UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051144-22352-7	36	25,000	2" 983C	50/200
051111-50005-7	50			
051144-22353-4	60			
051144-22354-1	80			
051144-22349-7	36	20,000	3" 983C	
051144-85890-3	50			
051144-22350-3	60			
051144-22351-0	80	12,000	4" 988C	
051111-55753-2	36			
051111-55754-9	50			
051111-55755-6	60			
051111-55756-3	80			

#### 3M™ Roloc™ Discs 988R ■

- 3M™ Ceramic abrasive grain
- Cuts through metal stock to quickly level welds and take on tough jobs in small areas
- A unique single-piece construction that can eliminate button delamination and enhance disc performance



UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051141-20626-4	24	25,000	2"	50/200
051141-20627-1	36			
051141-20628-8	50			
051141-20629-5	60			
051141-20630-1	80	20,000	3"	
051141-20024-8	24			
051141-20025-5	36			
051141-20026-2	50			
051141-20030-9	60			
051141-20027-9	80			

■ Mild Steel ■ Stainless Steel

See pages 72–77 for available accessories.

### 3M™ Roloc™ Discs

#### 3M™ Roloc™ Disc 361F ■

- Aluminum oxide on a YF wt. cloth backing
- General purpose grinding, blending and finishing on all metals



UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b>				
051144-11412-2	36	30,000	1"	50/500
051144-11411-5	50			
051144-11417-7	60			
051144-11416-0	80			
051144-11415-3	P100			
051144-11414-6	P120			
051144-11452-8†	24	30,000	1-1/2"	
051144-22396-1	36			
051144-11137-4	50			
051144-22397-8	60			
051144-22407-4	80			
051144-22408-1	P100			
051144-22409-8	P120	25,000	2"	
051144-11000-1	24			
051144-22398-5	36			
051144-22399-2	50			
051144-22400-5	60			
051144-22401-2	80			
051144-22402-9	P100			
051144-22403-6	P120			
051144-14559-1	P150			
051144-13873-9	P180			
051144-11419-1	P240			

† Made-to-Order

#### 3M™ Roloc™ Disc 361F (cont.)

UPC	Grade	Max. RPM	Diameter	Min./Case		
<b>Roloc TR (Plastic Button)</b>						
051144-22392-3	24	20,000	3"	50/200		
051144-22393-0	36					
051144-22394-7	50					
051144-22395-4	60					
051144-22404-3	80					
051144-22405-0	P100					
051144-22406-7	P120	12,000	4"			
051144-82244-7	P150					
051144-11418-4	P240					
051144-76429-7	36					
051144-11421-4	60					
051144-11420-7	80				<b>Roloc TSM (Metal Button)</b>	
051111-49932-0	36	30,000	1-1/2"	50/500		
051111-49933-7	60					
051111-49934-4	80					
051111-51039-1	P100					
051111-51038-4†	P120					
051111-49936-8	36				25,000	2"
051111-49937-5	60					
051111-49938-2	80					
051111-51034-6	P100					
051111-49939-9	P120					
051111-51033-9	36	20,000	3"			
051111-49940-5	60					
051111-49941-2	80					
051111-49942-9	P100					
051111-49943-6	P120			<b>Roloc TP (Metal Button)</b>		
051111-82401-4	40			25,000	2"	50/200
051111-76806-6	60					
051111-76810-3	80					
051111-77115-8†	100	20,000	3"			
051111-22393-0	36					
051111-22394-7	50					
051111-22395-4	60					
051111-22404-3	80					
051111-22405-0	P100					

† Made-to-Order

■ Mild Steel ■ Stainless Steel

See pages 72–77 for available accessories.


### 3M™ Roloc™ Discs (cont.)

#### 3M™ Roloc™ Disc 461F

- Silicon carbide on a YF wt. cloth backing gives stainless steel a brighter finish
- Ideal for grinding glass, titanium and non-ferrous metals



51704



UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051144-12956-0	P60	25,000	2"	50/200
051144-12954-6	P80			
051144-12957-7	P60	20,000	3"	
051144-12955-3	P80			

#### 3M™ Roloc™ Fibre Disc 501C ■

- Aluminum zirconia – Fibre
- Versatile disc for use on a wide variety of metals



159108

UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051141-20645-5	36	25,000	2"	50/200
051111-50748-3	50			
051111-50749-0	60			
051111-50750-6	80			
051111-50743-8	36	20,000	3"	
051111-50744-5	50			
051111-50745-2	60			
<b>Roloc TSM (Metal Button)</b> 				
051111-50755-1	36	25,000	2"	50/200
051111-50756-8	50			
051111-50757-5	60			
051111-50758-2	80			
051111-50751-3	36	20,000	3"	
051111-50752-0	50			
051111-50753-7	60			
051111-50754-4	80			

■ Mild Steel ■ Stainless Steel

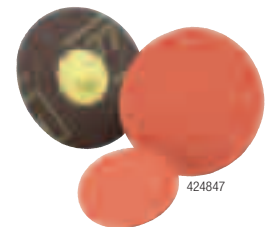
See pages 72–77 for available accessories.




524509

#### 3M™ Roloc™ Disc 777F ■

- 3M™ Ceramic Aluminum Oxide blend abrasive grain
- Cloth backing for durability
- Grinding aid for cooler running






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UPC	Grade	Max. RPM	Diameter	Min./Case		
<b>Roloc TR (Plastic Button)</b> 						
051144-76622-2	36	30,000	1"	50/500		
051144-76623-9	50					
051144-76624-6	60					
051144-76625-3	80					
051144-80510-5	P120	25,000	2"		50/200	
051144-76626-0	36					
051144-76627-7	50					
051144-76628-4	60					
051144-14660-4	80	20,000	3"			
051144-80511-2	P120					
051144-76629-1	36					
051144-76630-7	50					
051144-76433-4	60	25,000	2"	50/200		
051144-14661-1	80					
051144-80508-2	P100					
051144-80512-9	P120					
051144-76631-4	36	20,000	3"		50/200	
051144-76632-1	50					
051144-76633-8	60					
051144-76634-5	80					
051144-80509-9	P100	20,000	3"			
051144-80513-6	P120					

### 3M™ Roloc™ Discs (cont.)

#### 3M™ Roloc™ Disc 777F (cont.)


UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TSM (Metal Button)</b> 				
051111-49949-8	36	25,000	2"	50/200
051111-50253-2	60			
051111-50254-9	80			
051111-50255-6	100			
051111-50256-3	P120			
051111-50257-0	36	20,000	3"	
<b>Roloc TP (Metal Button)</b> 				
051144-76770-0†	60	25,000	2"	50/200
051144-76743-4†	36	20,000	3"	
051144-76763-2†				
051144-76767-0†				
051144-76767-0†				
<b>Roloc TS (Plastic Button)</b> 				
051144-76742-7	36	25,000	2"	50/200
051144-76746-5	50			
051144-76750-2	60			
051144-76743-4†	36	20,000	3"	
051144-76747-2†	50			
051144-76751-9	60			
051144-76755-7	80			

† Made-to-Order

#### 3M™ Roloc™ Fibre Disc 785C

- 3M™ Ceramic Aluminum Oxide blend abrasive grain – Fibre
- An excellent starting point for stainless steel
- Includes a grinding aid for cooler running

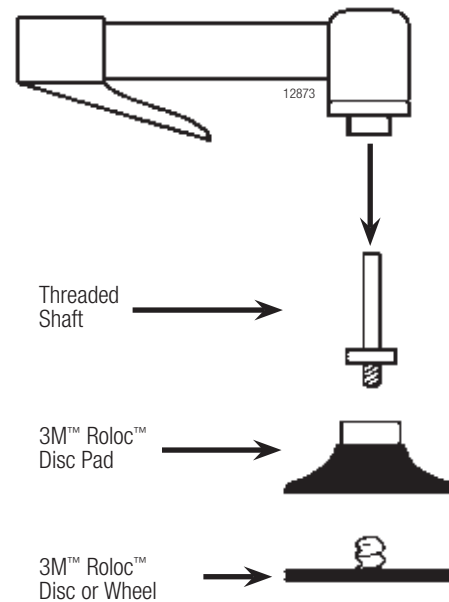


UPC	Grade	Max. RPM	Diameter	Min./Case
<b>Roloc TR (Plastic Button)</b> 				
051144-85882-8†	24	20,000	3"	50/100
051144-85883-5	36			
051144-85884-2	50			
051144-85885-9	60			
051144-85886-6	80			
051144-85887-3	P100	12,000	4"	25/100
051144-85888-0	P120			
051144-83690-1	36			
051144-83691-8	50			
051144-83692-5	60			
051144-83693-2	80	P100		
051144-83694-9	P120			
051144-83695-6	P120			

† Made-to-Order

 Mild Steel  Stainless Steel

See pages 72–77 for available accessories.




### 3M™ Roloc™ Discs (cont.)

#### 3M™ Roloc™ Cloth Disc 963G ■

- 3M™ Ceramic abrasive grain
- Durable cloth backing

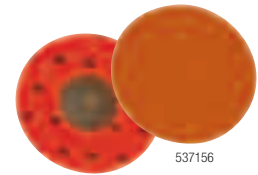




UPC	Grade	Max. RPM	Diameter	Min./Case		
<b>Roloc TR (Plastic Button)</b> 						
051144-11422-1†	50	30,000	1"	50/500		
051144-11428-3	60					
051144-11427-6	80					
051144-11425-2	120					
051144-11450-4	36					
051144-11448-1	60		1-1/2"			
051144-11455-9	80					
051144-11454-2†	100					
051144-11453-5	120					
051144-11113-8	24				25,000	2"
051144-11112-1	36					
051144-76436-5	40					
051144-11111-4	50					
051144-11110-7	60					
051144-11109-1	80					
051144-11107-7	100					
051144-11106-0	120					
051144-11108-4	24	20,000	3"			
051144-11105-3	36					
051144-11104-6	50					
051144-11103-9	60					
051144-11102-2	80					
051144-11101-5	100					
051144-11100-8	120					

† Made-to-Order

#### 3M™ Roloc™ Durable Edge Disc 977F ■

- 3M™ Ceramic abrasive grain
- Features a durable backing and a grinding aid
- For grinding, blending and deburring of light to medium pressure applications for virtually all metal types



UPC	Grade	Max. RPM	Diameter	Min./Case		
<b>Roloc TR (Plastic Button)</b> 						
051144-24094-7	36	25,000	2"	50/200		
051144-24096-1	50					
051144-24098-5	60					
051144-24100-5	80					
051144-24095-4	36	20,000	3"			
051144-24097-8	50					
051144-24099-2	60					
051144-24102-9	80					
<b>Roloc TSM (Metal Button)</b> 						
051141-24005-3	36	30,000	1-1/2"	50/500		
051141-27348-8†	36			25,000	2"	50/200
051141-27393-8	50					
051141-27346-4†	60					
051141-27347-1†	36					
051141-27392-1†	50	25,000	2"			
051141-27345-7†	60					

† Made-to-Order

■ Mild Steel ■ Stainless Steel

See pages 72–77 for available accessories.