

**3M** Science.  
Applied to Life.™

Plating and Polishing Application Guide

For the finest  
finishes.

Featuring 3M™ Cubitron™ II  
Cloth Belt 726A



Learn more about polishing belts at [3M.com/Polishing](https://www.3M.com/Polishing)


# Experience the benefits of cutting-edge technology and industry expertise with our winning abrasive combinations.

Unlock the full potential of your industrial finishing or plating processes with our winning abrasive combinations. By combining our premium 3M™ Cubitron™ II Cloth Belt 726A with 3M™ Trizact™ Cloth Belts, you could achieve more consistent finishes with less time and effort, helping you increase productivity and efficiency.

Productivity Delivered 

Consistent Quality 

Long Life 

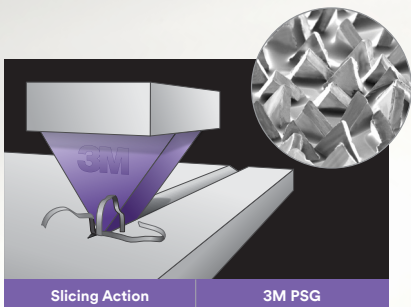
Automation Ready 

## 3M technologies paired for industrial work.



### 3M Precision-Shaped Grain (PSG)

The innovative slicing action of 3M™ Cubitron™ II Abrasives helps deliver a cooler, faster cut at any grinding pressure. The PSG will fracture when blunt creating a new sharp cutting point for super-long abrasive life. Sharp cutting helps get the job done faster, reducing exposure to hand-arm vibration. Swarf stays airborne for less time, minimizing airborne particles exposure of the operator.

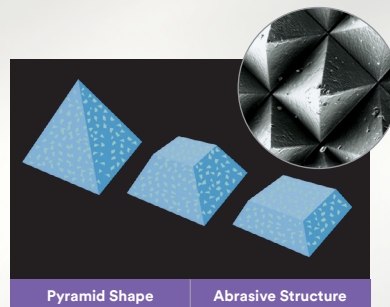


Scan to learn more



### 3M Microreplication Technology

The uniform configuration of 3M™ Trizact™ Abrasives helps deliver more consistent, predictable finishes, higher, more even rates of cut, cooler grinding and finishing temperatures, and ultimately, fewer processing steps for greater productivity. The abrasive mineral is contained in three-dimensional microreplicated structures evenly distributed across a backing in a precise pattern. As the peaks of these pyramid-like structures wear away, fresh cutting mineral is exposed — all the way to the backing.



Scan to learn more



### 3M Customer Abrasive Methods (CAM) Center

Located at 3M's headquarters in St. Paul, Minnesota, the CAM Center was established to help customers identify the most cost-effective combination of abrasives, equipment and techniques for their particular applications. At the CAM Center, evaluations are carried out under controlled, repeatable conditions using a wide array of production scale grinding, polishing and finishing equipment, as well as in our on-site research and testing laboratories. The services of the 3M CAM Center include applications development, process optimization, operator training and other technical support. Contact your local 3M representative for more information.

*“With winning combinations, we’ve combined the best of our abrasive technologies to help you succeed in every step of your abrasive process.”*



Eric Askeland,  
3M Application Engineer

Get the Winning  
Abrasive  
Combination

## Plating and Polishing

When your project demands a fine, consistent finish, you need an abrasive that can produce the results you need. 3M Abrasive belts deliver consistent, refined performance in metal polishing and prep for plating applications. Whether you need to achieve a mirror finish on stainless steel or generate a spec-required aesthetic finish, 3M™ Cubitron™ II and Trizact™ abrasives deliver the consistent polishing performance you demand.



Automotive  
Parts



Building  
Hardware



Hand Tools  
and Cutlery



Medical Tools  
and Implants



Plumbing  
Fixtures



Turbine  
Blades



# Prepping Steel Prior to Plating Chrome

## Get the Winning Abrasive Combination

### Step 1: Dimensioning and Defect Removal

#### 3M™ Cubitron™ II Cloth Belt 726A

80+ 120+ 150+ 180+ 220+ 240+

Choose your starting grade depending on the finish of the incoming part and your final finish requirement



### Step 2: Finishing and Polishing

The final finish before plating is typically around 16 Ra

#### For More Flexibility

#### 3M™ Trizact™ Cloth Belt 217EA

A45 A30 A16

J-weight rayon backing, more flexibility



#### For More Stability

#### 3M™ Trizact™ Cloth Belt 237AA

A45 A30 A16

X-weight poly-cotton backing, choose for more stability



### Tech Tip:



#### Contact Wheels

As you move into the finer grades, move away from serrated contact wheels and use lower durometer smooth face contact wheels (e.g., foam wheels, soft rubber wheels, soft cotton wheels, etc.). Typically, a softer full face contact wheel will produce a finer finish that is easier to buff or plate than a stiff or serrated contact wheel.



#### Contact Wheel Dressing

Wheel balance and trueness become increasingly more important as you progress into the finer grades. To dress your contact wheel: adhere a new piece of coated abrasive (grade 50 to 120) to a flat board or plate steel. Hold this lightly, but firmly against the rotating contact wheel until the wheel is concentric.

**Note:** It is important to use light pressure. Higher pressure can aggravate the wheel's out-of-round condition.



# Achieving a #8 Stainless Steel Finish/Mirror Finish

## Get the Winning Abrasive Combination

### Step 1: Dimensioning and Defect Removal

#### 3M™ Cubitron™ II Cloth Belt 726A

80+ 120+

Choose your starting grade depending on the finish of the incoming part and your final finish requirement



### Step 2: Finishing and Polishing

#### For More Flexibility

#### 3M™ Trizact™ Cloth Belt 217EA

A100 A45 A30 A16 A6

J-weight rayon backing, more flexibility



#### For More Stability

#### 3M™ Trizact™ Cloth Belt 237AA

A100 A45 A30 A16 A6

X-weight poly-cotton backing, choose for more stability



### Step 3: Mirror Finish

#### Final Polishing and Buffing

Use a buffing wheel and compound to achieve a mirror finish

For other decorative finishes and complex parts, try Scotch-Brite™ Convolute Wheels.



#### Metal Finishing

create a satin finish somewhat duller and coarser than our light deburring wheels.



#### Multi-Finishing

create a bright finish with a wide scratch pattern.



#### Cut and Polish

produce a dull finish with a tight scratch pattern.



#### Light Deburring

produce a bright and consistent finish with a tight scratch pattern.

#### Tech Tip:



#### Pharmaceutical or Dairy Finish

To obtain a surface finish less than a 32 Ra micro-inch finish for pharmaceutical or dairy finishing applications, refine the area after Step #2 with a 3M™ Trizact™ Cloth Belt 237AA grade A100 belt followed by a final step using a Scotch-Brite™ Surface Conditioning Belt grade A VFN.

## 3M™ Cubitron™ II Cloth Belts

### Flexibility meets productivity.

Tackle low-pressure applications with 3M™ Cubitron™ II Cloth Belt 726A — specifically designed to cut fast and deliver consistent finishes on contoured parts. Works on carbon and stainless steel, aluminum, copper and titanium.

#### 3M™ Cubitron™ II Cloth Belt 726A for Plating and Polishing

3M ID	Mineral	Backing	Grinding Aid	Use Dry/Wet
726A	3M Precision-Shaped Grain	Flex J-weight	Yes	Dry

Grades **80+** **120+** **150+** **180+** **220+** **240+** **320+** **400+**



**Configurable Belts 726A**  
Made-to-order in the size you need.

3M Stock #	Grade
7100289610	80+
7100289609	120+
7100289608	150+
7100289607	180+
7100289606	220+
7100289605	240+
7100289604	320+
7100289603	400+

## 3M™ Cubitron™ II Cloth Belt 726A

- A high-quality flexible belt — at exceptional value
- Specifically designed to cut fast and deliver consistent finishes on contoured parts

UPC	W x L	Grade	Min/Case
00-68060-65876-0	2" x 72"	120+	50
00-68060-65877-7	2" x 72"	150+	50
00-68060-65878-4	2" x 72"	180+	50
00-68060-65879-1	2" x 72"	220+	50
00-68060-65880-7	2" x 72"	240+	50
00-68060-65855-5	2" x 118"	120+	50
00-68060-65856-2	2" x 118"	150+	50
00-68060-65857-9	2" x 118"	180+	50
00-68060-65858-6	2" x 118"	220+	50
00-68060-65859-3	2" x 118"	240+	50
00-68060-65883-8	2" x 132"	120+	50
00-68060-65884-5	2" x 132"	150+	50
00-68060-65885-2	2" x 132"	180+	50
00-68060-65886-9	2" x 132"	220+	50
00-68060-65887-6	2" x 132"	240+	50
00-68060-65862-3	3" x 118"	120+	50
00-68060-65863-0	3" x 118"	150+	50
00-68060-65864-7	3" x 118"	180+	50
00-68060-65865-4	3" x 118"	220+	50
00-68060-65866-1	3" x 118"	240+	50
00-68060-65890-6	3" x 132"	120+	50
00-68060-65891-3	3" x 132"	150+	50
00-68060-65892-0	3" x 132"	180+	50
00-68060-65893-7	3" x 132"	220+	50
00-68060-65894-4	3" x 132"	240+	50
00-68060-65869-2	4" x 118"	120+	50
00-68060-65870-8	4" x 118"	150+	50
00-68060-65871-5	4" x 118"	180+	50
00-68060-65872-2	4" x 118"	220+	50
00-68060-65873-9	4" x 118"	240+	50

## 3M™ Trizact™ Cloth Belts

### Ideal where consistent, refined finishes are essential.

3M™ Trizact™ Cloth Belts are ideal for work where consistent, refined finishes are essential. Cool-running Trizact™ abrasives delivers refined performance even on hard metals such as carbon or stainless steel, and helps reduce warping and discoloration. And the mineral abrasive stays sharp as it wears.

#### 3M™ Trizact™ Belts for Plating and Polishing

3M ID	Mineral	Backing	Description	Use Dry/Wet
217EA	Aluminum Oxide	Flex J-weight	Low Pressure	Dry
237AA	Aluminum Oxide	Semi Flex X-weight	Low-Med Pressure	Dry

Grades **A160** **A100** **A80** **A65** **A45** **A30** **A16** **A6**

#### 3M™ Trizact™ Belt Grading System

The unique construction of Trizact™ abrasives requires a different grading system. Grade is defined by the average particle size in microns and begins with an "A".

Trizact Abrasive Grade	FEPA (P-Grade)
A6	P2000
A16	P1200
A30	P600
A45	P400
A65	—
A80	—
A100	P180
A160	P120

## 3M™ Trizact™ Cloth Belts

### 3M™ Trizact™ Cloth Belt 217EA

- Ideal for aluminum, copper, brass and zinc alloys to final finishing
- Good for low pressure applications
- Flexible belt for intermediate finish and dimensioning



UPC	W x L	Grade	Min/Case
051125-23664-5	4" x 84"	A45	50
051125-15686-8	4" x 106"	A45	50
051125-20639-6	4" x 118"	A6	50
051125-14350-9	4" x 118"	A16	50
051111-66834-4	4" x 118"	A30	50
051125-13733-1	4" x 118"	A45	50

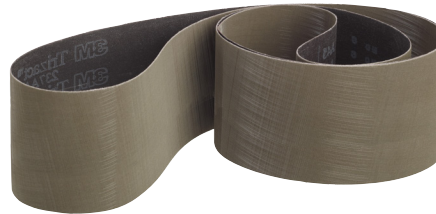
UPC	W x L	Grade	Min/Case
051111-66830-6	4" x 132"	A6	50
051111-69360-5	4" x 132"	A16	50
051111-66835-1	4" x 132"	A30	50
051111-66841-2	4" x 132"	A45	50
051125-12699-1	4" x 168"	A30	50

**Configurable Belts 217EA**  
Made-to-order in the size you need.

3M Stock #	Grade
7100052788	A6
7100052787	A16
7100052786	A30
7100052768	A45
7100052770	A65
7100052769	A80
7100052771	A100

### 3M™ Trizact™ Cloth Belt 237AA

- Semi-flexible abrasive
- Aluminum oxide mineral
- Great choice for stainless steel finishes



UPC	W x L	Grade	Min/Case
051119-82624-1	1" x 11"	A6	500
051125-32361-1	1" x 11"	A16	500
051115-27208-0	1" x 11"	A45	500
051111-69366-7	1" x 11"	A100	500
051125-22681-3	1" x 12"	A100	200
051111-69377-3	1" x 30"	A30	200
051125-15699-8	1" x 42"	A16	200
051125-08603-5	1" x 42"	A100	200
051119-10286-4	1" x 60"	A45	200
051119-10263-5	1" x 64"	A6	200
051111-66945-7	1" x 130"	A100	50
051115-27804-4	2" x 34"	A100	50
051111-69673-6	2" x 48"	A16	25/50
051115-27731-3	2" x 48"	A30	50
051119-09379-7	2" x 48"	A45	50
051111-69043-7	2" x 48"	A100	50
051125-54544-0	2" x 60"	A100	50
051115-27487-9	2" x 72"	A16	50
051115-27653-8	2" x 72"	A30	50
051111-69671-2	2" x 72"	A100	25/50
051125-22263-1	2" x 118"	A30	50
051111-66856-6	2" x 132"	A6	50
051111-69370-4	2" x 132"	A16	25/50
051115-27658-3	2" x 132"	A30	50
051111-69028-4	2" x 132"	A45	50
051111-69044-4	2" x 132"	A100	50
051125-20169-8	2" x 148"	A100	50
051111-69294-3	3" x 24"	A6	10/50
051111-69290-5	3" x 24"	A16	10/50
051111-69291-2	3" x 24"	A30	10/50
051119-83067-5	3" x 60"	A16	50
051111-69045-1	3" x 60"	A100	50

UPC	W x L	Grade	Min/Case
051111-69021-5	3" x 90"	A30	50
051111-69022-2	3" x 118"	A30	50
051125-19954-4	3" x 132"	A6	50
051111-51199-2	3" x 132"	A16	25/50
051111-51207-4	3" x 132"	A30	50
051111-51209-8	3" x 132"	A45	50
051111-66864-1	3" x 148"	A16	50
051111-69292-9	3" x 148"	A30	25/50
051111-69293-6	3" x 148"	A45	25/50
051111-66949-5	4" x 36"	A100	50
051119-68279-3	4" x 48"	A100	50
051115-27749-8	4" x 90"	A6	50
051111-69016-1	4" x 90"	A16	50
051111-51204-3	4" x 90"	A30	50
051111-69030-7	4" x 90"	A45	50
051111-69672-9	4" x 90"	A100	25/50
051115-27153-3	4" x 106"	A30	50
051115-26818-2	4" x 106"	A100	50
051111-66867-2	4" x 118"	A16	50
051111-66878-8	4" x 118"	A30	50
051111-66888-7	4" x 118"	A45	50
051125-17651-4	4" x 118"	A100	50
051111-69251-6	4" x 132"	A6	25/50
051111-69017-8	4" x 132"	A16	50
051111-51214-2	4" x 132"	A30	50
051111-69031-4	4" x 132"	A45	50
051111-69048-2	4" x 132"	A100	50
051115-27521-0	4" x 168"	A16	50
051119-10264-2	4" x 168"	A30	50
051111-68739-0	4" x 354"	A100	20

**Configurable Belts 237AA**  
Made-to-order in the size you need.

3M Stock #	Grade
7100007882	A6
7100007878	A16
7100007880	A30
7100007881	A45
7100007883	A65
7100007884	A80
7100007877	A100
7100007879	A160

**Note:** Belts are available in other grades and sizes. If you need a specific belt not listed, contact your 3M Sales Specialist or 3M Authorized Distributor.

## Scotch-Brite™ Convolute Wheels

# For decorative finishes of complex parts.

Scotch-Brite™ Convolute Finishing Wheels generate surface finishes and blend or refine scratches to create aesthetically pleasing looks. These wheels are designed to apply a variety of uniform finishes such as aesthetic satin finishes, antique finishes, matte finishes, and matching #3 mill and #4 mill finishes. Achieve your desired finish in fewer steps, in less time and with less effort.

### Scotch-Brite™ Convolute Wheel Application Guide

Scotch-Brite™ Convolute Wheel	Deburring	Blending	Finishing	Polishing
EXL / EX2 / EX3 Deburring (EXL)	✓	✓		
EXL Pro Deburring (EXL Pro)	✓			
Metal Finishing (MF)		✓	✓	
Cut and Polish (CP)		✓	✓	✓
Multi-Finishing (MU)		✓	✓	
Light Deburring (LDW)			✓	✓

Recommended Operating Speeds				
Application	Finishing	Composites / Soft Materials	Deburring	Blending / Polishing
Surface Feet Per Minute	500 – 3,000	1,200 – 2,700	5,000 – 7,500	6,000 – 8,000

## Scotch-Brite™ Metal Finishing Wheels

- For decorative finishing and blending — designed to apply uniform and consistent satin, antique, mill and brushed finishes on metals
- Highly conformable
- Removes minor imperfections and handling marks



3M ID	Size	Grade	Max RPM
7010365657	6" x 1" x 1"	4A CRS	6,000
7100042616	6" x 1" x 1"	5A CRS	6,000
7100111501	6" x 1" x 1"	6A CRS	6,000
7000120596	6" x 1" x 1"	4A MED	6,000
7100003943	6" x 1" x 1"	5A MED	6,000
7010365658	6" x 1" x 1"	6A MED	6,000

## Scotch-Brite™ Multi-Finishing Wheels

- For decorative, satin finishing and blending of all metals in fewer steps
- Often used on inline sanding tools for large surface repair
- Produces a bright finish with a wide scratch pattern



3M ID	Size	Grade	Max RPM
7100006330	6" x 1" x 1"	2S CRS	6,000
7000136469	6" x 1" x 1"	2S MED	6,000
7000136471	6" x 1" x 1"	2S FIN	6,000

**Note:** Wheels are available in other grades and sizes. If you need a specific wheel not listed, contact your 3M Sales Specialist or 3M Authorized Distributor.

Learn about more 3M Abrasive belt solutions at [3M.com/MetalworkingBelts](https://www.3m.com/MetalworkingBelts)



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