

**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 

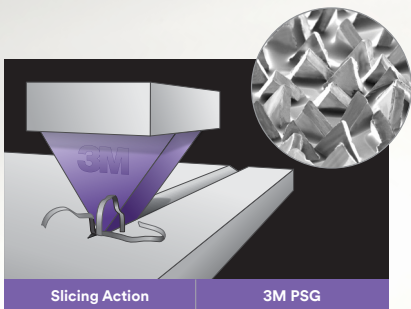
Automation Ready 

## 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.

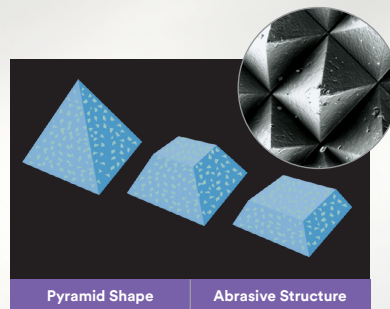


Scan to learn more



### 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 |
|------------|-------|
| 7100406422 | 80+   |
| 7100406421 | 120+  |
| 7100406420 | 150+  |
| 7100406419 | 180+  |
| 7100406418 | 220+  |
| 7100406417 | 240+  |
| 7100406416 | 320+  |
| 7100406415 | 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

| SAP ID     | W x L     | Grade | Min/Case |
|------------|-----------|-------|----------|
| 7100404975 | 2" x 72"  | 80+   | 50       |
| 7100404972 | 2" x 72"  | 120+  | 50       |
| 7100404977 | 2" x 72"  | 150+  | 50       |
| 7100404702 | 2" x 72"  | 180+  | 50       |
| 7100405046 | 2" x 72"  | 220+  | 50       |
| 7100404701 | 2" x 72"  | 240+  | 50       |
| 7100405069 | 2" x 72"  | 320+  | 50       |
| 7100404929 | 2" x 72"  | 400+  | 50       |
| 7100404788 | 2" x 118" | 80+   | 50       |
| 7100404978 | 2" x 118" | 120+  | 50       |
| 7100404918 | 2" x 118" | 150+  | 50       |
| 7100405089 | 2" x 118" | 180+  | 50       |
| 7100405038 | 2" x 118" | 220+  | 50       |
| 7100405056 | 2" x 118" | 240+  | 50       |
| 7100404916 | 2" x 118" | 320+  | 50       |
| 7100404890 | 2" x 118" | 400+  | 50       |
| 7100405088 | 2" x 132" | 80+   | 50       |
| 7100404892 | 2" x 132" | 120+  | 50       |
| 7100405010 | 2" x 132" | 150+  | 50       |
| 7100405113 | 2" x 132" | 180+  | 50       |
| 7100405096 | 2" x 132" | 220+  | 50       |
| 7100405009 | 2" x 132" | 240+  | 50       |
| 7100404970 | 2" x 132" | 320+  | 50       |
| 7100404860 | 2" x 132" | 400+  | 50       |
| 7100404762 | 3" x 118" | 80+   | 50       |
| 7100404751 | 3" x 118" | 120+  | 50       |
| 7100405116 | 3" x 118" | 150+  | 50       |
| 7100405105 | 3" x 118" | 180+  | 50       |
| 7100404867 | 3" x 118" | 220+  | 50       |
| 7100405104 | 3" x 118" | 240+  | 50       |
| 7100405094 | 3" x 118" | 320+  | 50       |
| 7100404832 | 3" x 118" | 400+  | 50       |
| 7100404912 | 3" x 132" | 80+   | 50       |
| 7100405081 | 3" x 132" | 120+  | 50       |
| 7100405114 | 3" x 132" | 150+  | 50       |
| 7100404930 | 3" x 132" | 180+  | 50       |
| 7100404582 | 3" x 132" | 220+  | 50       |
| 7100404976 | 3" x 132" | 240+  | 50       |
| 7100405103 | 3" x 132" | 320+  | 50       |
| 7100405037 | 3" x 132" | 400+  | 50       |

## 3M™ Trizact™ Cloth Belts

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           |

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

## 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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