

SCOTCH-BRITE™ ABRASIVE WHEELS FOR ROBOTIC BRAZE BLENDING AND CLEANING

A BETTER WAY TO LEVEL & PREP

A **COMPLETE LINE** of advanced non-woven abrasive wheels – optimized for robotic blending and cleaning of laser-brazed joints. The high-performance alternative.



3M

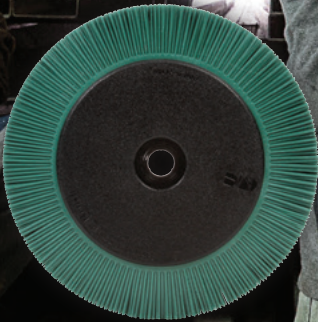
IT'S TIME TO GO WIRELESS



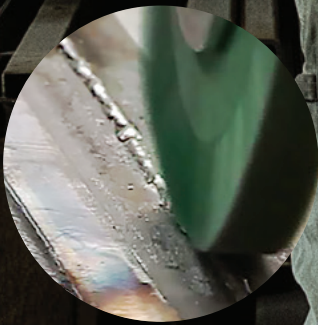
SCOTCH-BRITE™ LASER BRAZE FINISHING WHEEL



SCOTCH-BRITE™ EXL PRO UNITIZED WHEEL



SCOTCH-BRITE™ RADIAL BRISTLE BRUSHES



Scotch-Brite high performance unitized wheels and bristle brushes are specifically designed for robotic and hand held leveling, finishing and cleaning of continuous brazed roof/body joints. These innovative wheels give you more precise control of cut and thickness than conventional wheels. This means there is less likelihood of contacting the steel from the roof, which can weaken the structure, or of degrading the zinc coating, which can compromise corrosion protection. To help you meet increasingly stringent safety standards, Scotch-Brite wheels contain no wire filaments.

Suggested Performance Settings

Wheel	Used for	Force Target	Force Range	Wheel Speed Target	Wheel Speed Range	Traverse Speed Target
LBFW	Smoother more refined brazed surfaces that don't require as much removal/leveling	4-5 lbf/17-22 N	2-9 lbf/9-40 N	6,200 SFPM/31.5 m/s (3000 RPM for an 8" Wheel)	4,000 - 8,000 SFPM/20-40 m/s	200 mm/s dependent on the cycle time requirement of the system
EXL Pro	Brazed joints with more variability/deeper pits and ripples	6-7 lbf/25-30 N	5-9 lbf/22-40 N	6,200 SFPM/31.5 m/s (3000 RPM for an 8" Wheel)	4,000 - 8,000 SFPM/20-40 m/s	200 mm/s dependent on the cycle time requirement of the system

mm - Millimeter
RPM - Rotation Per Minute
SFPM - Surface Feet Per Minute

N - Newtons (unit of measure smaller than pound)
lbf - pounds of force

SCOTCH-BRITE™ ABRASIVE WHEELS FOR ROBOTIC BRAZE BLENDING AND CLEANING

KEEP THE LINE MOVING

INNOVATIVE ABRASIVE
PRODUCTS – FOR THE WAY
YOU BUILD CARS TODAY



SCOTCH-BRITE™ LASER BRAZE FINISHING WHEEL

FOR
SMOOTHER
BRAZED
JOINTS

- ✓ Made with 3M precision-shaped grain, for long life, fewer wheel changes
- ✓ Fast braze leveling and soot removal
- ✓ Delivers a predictable, consistent and smooth finish throughout the life of the wheel
- ✓ Precise control of wheel thickness within ± 0.2 millimeters

Scotch-Brite Laser Braze Precise control of wheel thickness within ± 0.2 millimeters and cleaning of continuous brazes on automotive roof and body joints.

These durable next-generation wheels keep on going longer between wheel changes, to help reduce downtime and improve your productivity. Plus, 3M's precision shaped grain technology delivers a consistently smooth, paintable finish throughout the life of the wheel.

SCOTCH-BRITE™ EXL PRO UNITIZED WHEEL

FOR
ROUGH-
SURFACED
BRAZED
JOINTS

- ✓ Extra-rugged construction, for higher pressure finishing applications with less than perfect brazed joints
- ✓ Fast braze leveling and soot removal
- ✓ Delivers a predictable, consistent and smooth finish
- ✓ Precise control of wheel thickness within ± 0.2 millimeters

These high performance unitized wheels are specifically designed for higher pressure robotic and hand held leveling, finishing and cleaning of continuous brazed joints on roof and body joints.

Featuring the same production-proven construction as our standard EXL wheels, these wheels provide fast, aggressive cutting action. Best of all, Scotch-Brite EXL PRO wheels give you more precise control over the cut than conventional wheels and wire brushes. This means there is less likelihood of removing steel from the adjacent panels.

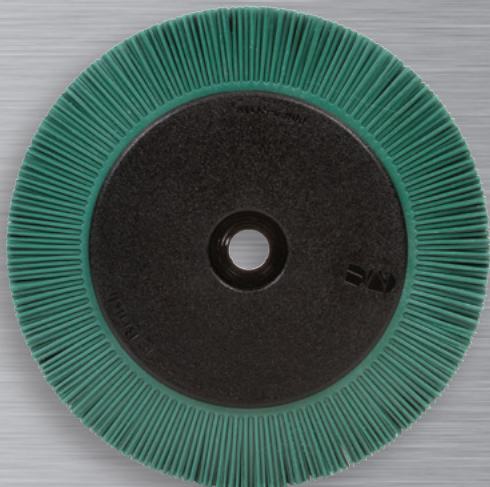
SCOTCH-BRITE™ RADIAL BRISTLE BRUSHES

FOR
SOOT
REMOVAL

- ✓ An excellent replacement for wire brushes
- ✓ No flying wires to cause safety concerns
- ✓ High cut rates, with less pressure
- ✓ Very strong and flexible

Ideal for removing soot or other surface contaminants, Scotch-Brite Bristle Brushes are constructed with flexible abrasive-filled bristles that require less pressure than wire brushes. They also conform to contours, even on complex parts, providing more surface contact than wire brushes.

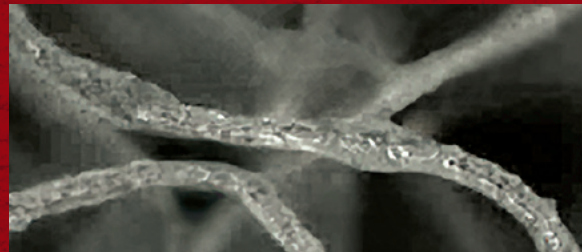
Scotch-Brite™ Radial Bristle Brushes contain proprietary 3M™ Ceramic Abrasive Grain, for a fast, consistent cut throughout the life of the brush.



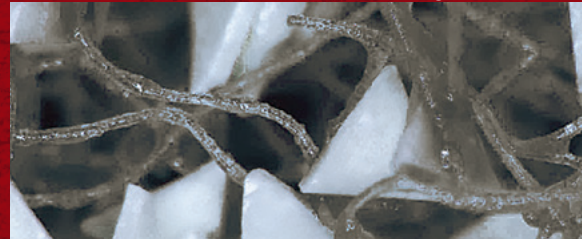
The non-woven difference

The secret behind the outstanding performance of these Scotch-Brite™ wheels lies in their non-woven, open web construction, which incorporates abrasive materials into a non-woven fiber matrix. Combining abrasives and non-woven material creates an abrasive system that delivers consistent results for the life of the product. The open-web material runs cool and is load resistant, which keeps the abrasive minerals cutting at high performance by limiting clogging of the fibers.

Scotch-Brite™ EXL PRO Unitized Wheel



Scotch-Brite™ Laser Braze Finishing Wheel



Ordering information

SCOTCH-BRITE™ EXL PRO UNITIZED WHEEL

UPC 076308-	Description	Size (inches) Diameter × thickness × center hole	Grade	Max. RPM	Qty/ Case
13267-5	EXL PRO Finishing Wheel – with flange, pilot holes	8 in. × 2.7 mm × 1 in.	8A CRS	5,500	10
13268-2		8 in. × 2.8 mm × 1 in.			
13269-9		8 in. × 3.0 mm × 1 in.			
13270-5		8 in. × 3.2 mm × 1 in.			
13271-2		8 in. × 3.5 mm × 1 in.			
13272-9		8 in. × 3.7 mm × 1 in.			
13273-6		8 in. × 4.2 mm × 1 in.			
13274 3		8 in. × 4.5 mm × 1 in.			
13275-0		8 in. × 4.7 mm × 1 in.			
13250-7		EXL PRO Finishing Wheel – pilot holes only			
13251-4	8 in. × 2.8 mm × 1 in.				
13252-1	8 in. × 3.0 mm × 1 in.				
13253-8	8 in. × 3.2 mm × 1 in.				
13254-5	8 in. × 3.5 mm × 1 in.				
13255-2	8 in. × 3.7 mm × 1 in.				
13256-9	8 in. × 4.2 mm × 1 in.				

All sizes available in multiple diameters and arbor holes.
3", 4", 6" and 9" sizes also available.

SCOTCH-BRITE™ LASER BRAZE FINISHING WHEEL

UPC 076308-	Size (inches) Diameter × thickness × center hole	Grade	Max. RPM	Qty/ Case
45815-7	8 in. × 4.7 mm × 1 in.	CRS+	5,500	10
45750-1	8 in. × 4.5 mm × 1 in.			
45751-8	8 in. × 4.2 mm × 1 in.			
45752-5	8 in. × 3.7 mm × 1 in.			
45753-2	8 in. × 3.5 mm × 1 in.			
45753-7	8 in. × 3.5 mm × 1 in.			
45754-9	8 in. × 3.2 mm × 1 in.			
45754-4	8 in. × 3.2 mm × 1 in.			
45755-1	8 in. × 3.0 mm × 1 in.			
45756-3	8 in. × 2.8 mm × 1 in.			
45756-8	8 in. × 2.8 mm × 1 in.			
45757-0	8 in. × 2.7 mm × 1 in.			
45757-5	8 in. × 2.7 mm × 1 in.			

Other sizes available.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.



Abrasive Systems Division
3M Center, Building 223-6S-03
St. Paul, MN 55144-1000
1-866-279-1235
www.3M.com/abrasives

Please recycle. Printed in USA.
© 3M 2018. All rights reserved.
Issued: 2/18 12720HB
61-5002-8439-5

3M and Scotch-Brite are trademarks of 3M.
Used under license by 3M subsidiaries and affiliates.