Now in High and Low Pressure Options!

3M™ Trizact™ CF Belts

327DC low • 337DC medium • 347AC high

DISTRIBUTED BY:

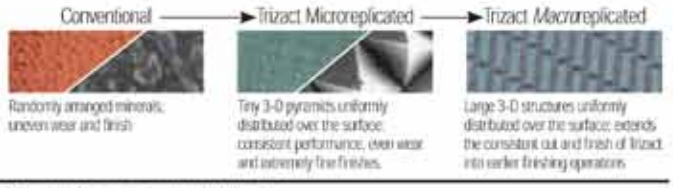
A.E. BLAKE SALES
LES VENTES A.E. BLAKE

For more information please contact us:

In Montreal at 1-800-879-5748
In Toronto at 1-888-664-2643
www.aeblake.ca

The consistent choice for intermediate blending & finishing

Evolution of Abrasives



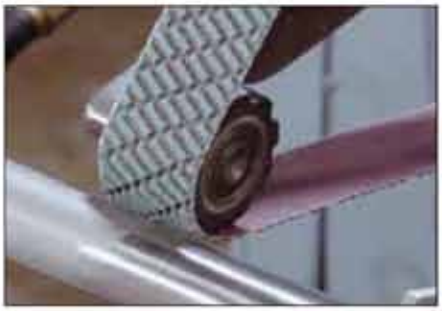
* Compared to conventional coated abrasives.

- Consistent Predictable Cut Rate
- Consistent, Predictable Finish
- More Parts per Belt
- Ability to Reduce Process Steps
- Capability of Lowering Overall Production Cost

3M

You have asked for 3M™ Trizact™ CF Abrasives to work on a variety of metals, equipment parameters, part shapes and conditions.

So we have expanded the CF family to include new low and high pressure options.



Low Pressure — Medium Pressure — High Pressure

Trizact CF 327DC
Low Pressure/Easy Breakdown

Use with:

- Soft contact wheels (60 Shore A and Less)
- Rubber, cotton or foam contact wheels
- Smooth face contact wheels
- Slack of belt applications
- Aluminum, zinc, and brass and other softer metals. Soft metals can quickly load belts, reducing belt life. Selecting an abrasive that breaks down easily under low pressure will help to avoid premature belt loading

Trizact CF 337DC
Medium Pressure/Original CF

Use with:

- Medium hardness contact wheel (50-70 Shore A)
- Rubber contact wheels
- Smooth face to gentle serrated contact wheel

337DC is a good starting point when not sure which product to choose.

If the 337DC:

- glazes over, caps, or loads too easily, try 327DC
- is worn to the backing too quickly or if shelling is experienced, try 347AC

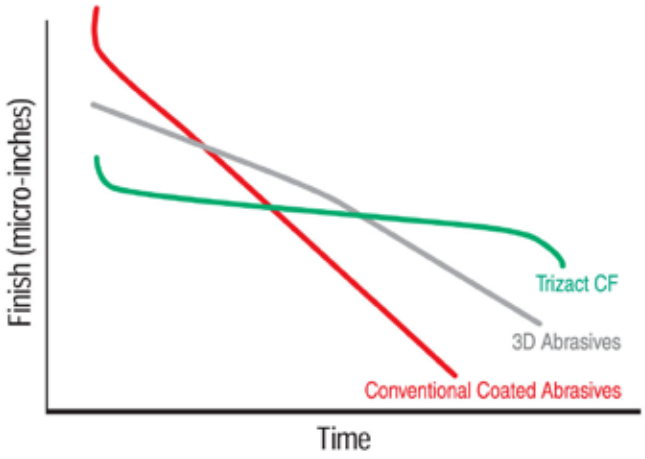
Trizact CF 347AC
High Pressure

Use with:

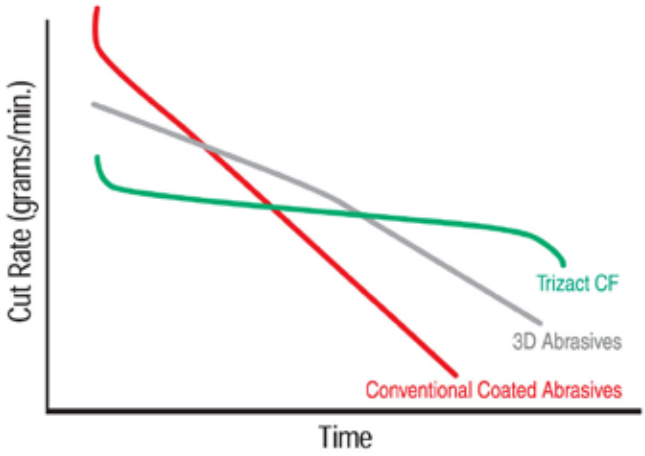
- Hard contact wheels (70 Shore A and Harder)
- Rubber contact wheels
- 1:1 serration or serr-X pattern contact wheel
- Harder metals: nickel alloys, titanium, and stainless steels
- Portable belt file tools using small diameter steel contact wheels
- Metal parts with jagged edges. Sharp edges can shell an abrasive product prematurely, choose 347AC with its more durable mineral and tougher backing

You asked. We delivered.

3M™ Trizact™ CF Abrasives "Brick" Advantage



3M™ Trizact™ CF Belt reaches new levels of consistency in finish.



3M™ Trizact™ CF Belt has a consistent cut rate throughout the life of the product

Can You Afford Not to Try 3M™ Trizact™ CF Belts?

- Lowering your overall production costs (cost per part)
- Utilize 3M resources to help optimize your abrasive processes, grade sequences and improve overall productivity
- Reduce product variability in terms of (less rejects and less rework):
  - Consistent cut rate and removal part-after-part
  - Consistent finish part-after-part
- Large, precise 3D structures consisting up to 4 times the mineral and grinding aids compared to conventional abrasives — longer belt life, more parts per belt.

Trizact Grade to FEPA Grade Conversion

3M™ Trizact™ Abrasive Grade (Average mineral size in microns)	FEPA (P-Grade)
A300	P80
A160	P120
A100	P180
A65	
	P240
A45	P320
	P400
A30	
	P600

Product Specifications

Available Grades	A300, A160, A100, A65, A45, A30
Mineral	Aluminum Oxide
Forms	Belts in 1/2" – 24" widths

Optimum Speeds Starting Points: Surface Feet Per Minute (SFPM)	
Aluminum	6000 – 7200
Zinc	6000 – 7200
Brass	6000 – 7200
Nickel Alloys	6000 – 8500
Stainless Steel	6000 – 7500
Carbon Steel	6000 – 7500
Titanium	2500 – 3500

Finishes Generated by Trizact™ Belts

Surface Finish Measurements, Ra (in micro-inches)

Mineral	Grade	Steel	Stainless	Brass	Aluminum	Titanium
Al2O3	A30	10 – 15	10 – 15	15 – 18	29 – 33	14 – 20
	A45	24 – 30	26 – 30	28 – 32	30 – 45	25 – 30
	A65	38 – 42	37 – 42	41 – 44	44 – 48	35 – 42
	A80	40 – 46	39 – 44	45 – 55	49 – 56	38 – 44
	A100	46 – 55	44 – 46	55 – 63	51 – 62	40 – 48

Conventional abrasives won't stack up to macroreplicated "Bricks"

Trizact™ CF Belt Consistency

Because of the uniformity and depth of the "bricks" comprising the 3M™ Trizact™ CF belt, mineral is always present at the working surface, resulting in a consistent, predictable cut rate and finish — from beginning to end.

Trizact CF Belt Life

The thickness of the "bricks" consists of layers of mineral and grinding aid, up to 4 times as much as conventional aluminum oxide belts of the same grade. That extra potential to get the job done can deliver 2 – 4 times more life over conventional belts and up to twice the life of other engineered or agglomerate belts. Plus, as the brick height diminishes, it serves as an indicator of how much life remains, removing any guesswork about belt changes.

Trizact CF Belt Cut Rate

Because CF sustains its cut rate from beginning to end, operators usually do not have to substantially increase pressure to offset declining cut rates as they do with conventional abrasives.

Applications:

Use for dry intermediate finishing, blending, scratch refinement or final dimensioning of robotic, semi-automated, automated, off-hand equipment and portable file belt tools.

Reduce Process Steps

The consistency with which Trizact CF belts refine scratches, combined with their increased volume of mineral and grinding aid, can often consolidate or eliminate process steps. The macroreplicated bricks deliver the same great results part after part, which can also reduce the need for rework.

Trizact CF Case Histories

Product	Application	Results
337DC Grades: A100, A65, A30 (Medium Pressure, original CF)	Carbon steel truck exhausts: Preparing drawn carbon steel truck exhausts from rough to pre-plate finishes in the least amount of steps. Polishing and plating.	Outlasted, by 2:1, a competitive 3D agglomerate (engineered) belt sequence and produced a finer, more consistent quality finish (Ra, Rmax).
337DC Grade A45 (Medium Pressure, original CF)	Stainless steel turbine engine components. Blending, final dimensioning, and finishing of turbine engine components.	Up to 4:1 abrasive belt life compared to a competitive conventional 400 grade aluminum oxide belt and produced a more consistent finish (Ra, Rz, and Rmax).
327DC Grade 160 (Low Pressure, easy breakdown)	Cobalt chrome orthopedic Implants. Casting scale removal and dimensioning.	Performed greater than 5:1 over a competitive P150 sol-gel abrasive belt.
3M™ Belt with Cubitron™ Abrasive Grain Grade 80 followed by **347AC** Grade A65 (High Pressure CF)	Stainless steel turbine engine components. Removal of coarse grade scratches, blending, final dimensioning and finishing.	Reduced a 3-step operation to a 2-step operation by leveraging an 80 grit 3M Belt with Cubitron abrasive followed by grade A65 in the 347AC; greater than 2:1 more parts per belt.
327DC Grade A300 followed by Grade A65 (Low Pressure, easy breakdown)	Titanium turbine engine components refining coarse grade scratches and final dimensioning.	A300 performed better than 2:1 over 100 grit conventional abrasive belt. Grade A65 performed better than 5:1 over a competitive 3D engineered abrasive belt.

Choose a Complete System

Using other 3M patented abrasive technologies: 3M™ Cubitron™ Abrasive Grain, Scotch-Brite™ Abrasives and 3M™ Trizact™ Abrasives for improved efficiency and competitiveness, including these new products.

Cubitron™
Abrasive Grain

3M-patented Cubitron™ Abrasive Grain is one of the hardest, longest-lasting minerals available. Cubitron Abrasives are engineered to cut fast and stand up to the intense heat and stress generated in heavy grinding applications. It is an ideal mineral for grinding, degating, descaling and rough dimensioning.

Trizact™ Abrasive Belts — for intermediate and final scratch refinement, Trizact belts can last two to five times longer than conventional belts — and finish so precisely that operators can reduce grade sequences, which in turn can lower abrasive and total manufacturing costs.

Scotch-Brite™

Abrasive Wheels, Belts and Discs

Whether deburring, blending, adding a radius or satin finish or just cleaning, nothing beats Scotch-Brite™ products for easily achieving a quality finish.

Product Use: All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

Warranty and Limited Remedy: Unless stated otherwise in 3M's product literature, packaging inserts or product packaging for individual products, 3M warrants that each 3M product meets the applicable specifications at the time 3M ships the product. Individual products may have additional or different warranties as stated on product literature, package inserts or product packages. **3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.** User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If the 3M product is defective within the warranty period, your exclusive remedy and 3M's and seller's sole obligation will be, at 3M's option, to replace the product or refund the purchase price.

Limitation of Liability: Except where prohibited by law, 3M and seller will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

3M
Industrial Business

3M, Cubitron, Scotch-Brite and Trizact are trademarks of 3M.

Please recycle.
Printed in U.S.A..
© 3M 2006. All rights reserved.
61-5002-8147-4