

SCS Grinding Guidelines

BACKGROUND

If You Use HRPO: SCS's smooth, dry finish and thin layer of scale presents a surface that may require some adjustments to your grinding. If grinding SCS accelerates pad wear or seems more difficult, please follow the recommendations below. Fabricators that have followed these recommendations have received equivalent or improved performance when grinding their HRPO; switching back and forth between different grinding procedures is not necessary.

If You Use Hot Rolled Black: Changes to your grinding practices are likely not required when using SCS; however, you may enjoy improved performance by following these recommendations

Recommendations for Light Grinding: Weld Spatter, Small Surface Imperfections, Light Scratches

- Use 3M Scotch Brite Clean and Strip Cup Wheel – or equivalent
- 4" Grinder with 5/8-11 threaded stud: – Cup Wheel 3M part # 34-7017-9867-9
- 6" Grinder with 5/8-11 threaded stud: use Adapter – 3M part # 051144-88769
Cup Wheel – 3M part # 38-9018-4694-9
- 6" Grinder Recommendation – Ingersoll-Rand model #88V60S106 pneumatic 90 deg rotary grinder
or equivalent 6000 rpm grinder

Recommendations for Heavy Grinding: Deep Scratches That Require Feathering, Weld Plugs

- Use 40 grit Abrasive Flap Disc
- 7" Grinder with 5/8"-11 threaded stud – flap disc is 3M part # 051111-01199
- 7" Grinder Recommendation – Milwaukee model #6088-20 or equivalent 7000 rpm grinder