

DRESSING STICKS

Regular use of properly selected dressing sticks will help you achieve maximum performance from your diamond and CBN wheels. Selected sticks are used for truing and dressing conventional vitrified wheels.



NORBIDE HIGH PERFORMANCE STICKS

For offhand truing and dressing of medium grit, soft and medium-grade vitrified grinding wheels; Norbide and Boron Carbide are the hardest sticks you can buy. Made from boron nitride, they are well suited for dressing tool and cutting wheels 10" and smaller, especially cup and saucer shapes

SIZE T X W X L*	STD. PKG.	BEST		BETTER	
		SPEC	UPC NO.	SPEC	UPC NO.
HIGH PERFORMANCE LONG LIFE STICKS					
3/16 X 7/16 X 3	5			BORON CARBIDE STICK	61463629472
3/16 X 1/2 X 3	5	NORBIDE STICK	61463610148		

* THICKNESS X WIDTH X LENGTH

VITRIFIED DRESSING STICKS

Aluminum Oxide (White) - Alundum

For dressing and cleaning CBN wheels; these sticks also work well for diamond wheels.

Silicon Carbide (Black) - Crystolon

Coarse grit (24) and hard-grade (R and harder) are used for dressing conventional vitrified wheels. Finer grit and softer grades are used for dressing diamond wheels.

SIZE T X W X L	STD. PKG.	BETTER	
		SPEC	UPC NO.
VITRIFIED DRESSING STICKS - A/O			
1/2 X 1/2 X 4	5	38A220-HVBE	61463610555
1/2 X 1/2 X 6	5	38A150-IVBE	61463610303
		38A220-HVBE	61463610103
1/2 X 3/4 X 4	5	38A60-LVBE	61463610415
3/4 X 3/4 X 4	5	38A60-LVBE	61463610440
		38A80-MVBE	61463610362
		38A150-HVBE	61463610291
		38A150-IVBE	61463610368
		38A220-HVBE	61463610290
3/4 X 3/4 X 8	5	38A220-HVBE	61463610280
1 X 1 X 6	5	38A150-HVBE	61463610405
		38A150-IVBE	61463610453
		38A220-HVBE	61463610406
1 X 1 X 8	5	38A120-IVBE	61463610390
		38A150-IVBE	61463610455

SIZE T X W X L	STD. PKG.	BETTER	
		SPEC	UPC NO.
VITRIFIED DRESSING STICKS - S/C			
1/2 X 1/2 X 6	5	37C24-SVK	61463610285
		37C100-LV	61463610201
		37C150-KV	61463610205
		37C150-LV	61463610206
		37C150-MV	61463610207
		37C220-KV	61463610214
3/4 X 3/4 X 6	5	37C24-SVK	61463610333
		37C150-LV	61463610375
1 X 1 X 6	5	37C20-SVK	61463610459
		37C24-SVK	61463610462
		37C24-TVK	61463610354
		37C46-RVK	61463610466
		37C80-NV	61463610393
		37C150-KV	61463610438
		37C220-KV	61463610398
		1 X 1 X 6 RETAIL CARDED	10
1 X 1 X 8	5	37C20-SVK	61463610469
1 X 2 X 8	5	37C24-SVK	61463610471
		37C16-TVK	61463610482
2 X 2 X 8	5	37C24-TVK	61463610485
		37C24-SVK	61463610490
VITRIFIED ROUND DRESSING STICK - S/C			
1/2 X 6 (DIAMETER X LENGTH)	5	37C24-SVK	61463610371

DRESSING STICKS

VITRIFIED SUPERFINE STICKS

For dressing the face of superabrasive wheels.

SIZE T X W X L	STD. PKG.	BETTER	
		SPEC	UPC NO.
VITRIFIED SUPERFINE STICKS			
1/4 X 3/4 X 4	5	NMVC280-P10VCA	61463650325
1/2 X 1/2 X 6	5	NMVC320-J5VCA	61463610599
		NMVC400-J5VCA	61463650324
		NMVC600-J8VCA	61463606881
		NSA320-G5V	61463610596
1 X 1 X 6	5	NMVC320-J5VCA	61463610605
		NMVC400-J5VCA	61463650450
1 X 1 X 8	5	NSA320-H8V	61463610597

OFF-HAND GRINDING WHEEL DRESSING STICK AND HOLDER

This convenient metal holder is widely used by mechanics and foundry-men for truing, dressing and changing the face of the wheel. The included JT246 dressing stick - a very coarse grit silicon carbide for dressing conventional vitrified wheels - is firmly held and adjusted by the knurled control.



SIZE	DESCRIPTION	MIN./STD. PKG.	GOOD	
			PRODUCT NO.	UPC NO.
GRINDING WHEEL DRESSING STICK & HOLDER				
1/2 X 6 ROUND	VERY COARSE S/C ROUND DRESSING STICK	5/10	JT246	61463687900
10 OVERALL	DRESSING STICK HOLDER	5/10	H6	61463687895

For more information on truing and dressing, please refer to the "Mounting, Truing and Dressing Guide" in the "Diamond Tool" section.

SpecCheck



Selecting the appropriate dressing stick for each application depends on the wheel size, type, speed, specification and grit size, as well as the material being worked. Initial starting specifications are listed below. We recommend testing several sticks to find the best one for your application.

STARTING RECOMMENDATIONS FOR DRESSING WHEELS

SUPERABRASIVE WHEELS	VITRIFIED STICK	
	PRODUCT	SPECIFICATION
RESIN AND VITRIFIED BOND		
- 80, 100 and 120 grit	Dressing Stick	38A150-HVBE
- 150, 180 and 220 grit	Dressing Stick	38A220-HVBE
- 320 and finer grits	Superfine Stick	NMVC400-J5VCA NMVC600-J8VCA
METAL BOND		
- 80, 100 and 120 grit	Dressing Stick	37C80-NV
- 150, 180 and 220 grit	Dressing Stick	37C150-KV
- 240 and finer grits	Dressing Stick	37C220-KV
CONVENTIONAL VITRIFIED WHEELS		
VITRIFIED BOND		
- 46 grit and finer and M grade and softer	High Performance or Dressing Stick	Norbide Stick 37C24-SVK

TechTips

Resin and Vitrified Bond, Diamond and CBN Wheels

- Choose a dressing stick one or two grit sizes finer than the abrasive in the wheel - in a soft grade (H or I).

Metal Bond, Diamond and CBN Wheels

- Choose a stick the same grit size or one grit size coarser than the abrasive in the wheel - in a medium grade (K-M).



It is the user's responsibility to refer to and comply with ANSI B7.1