



Regular use of properly selected dressing sticks will help you achieve maximum performance from your grinding wheels.

**Applications:**  
**Grit Range:**  
**Abrasive Grain:**  
**Shape:**  
**Machine Used:**

Truing, cleaning, and dressing diamond, cBN, and conventional abrasive grinding wheels  
16 – 1200  
Aluminum Oxide, Boron Nitride, Silicon Carbide  
Square, rectangular, and round



HAND DRESSING

### Grinding Wheel-to-Product Recommendation Guide

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



	Product	Specification
<b>Superabrasive Wheels - Resin and Vitrified Bond</b>		
- 80, 100, and 120 grits	Dressing Stick	38A150-HVBE
- 150, 180, and 220 grits	Dressing Stick	38A220-HVBE
- 320 and finer grits	Superfine Stick	NMVC400-J5VCA
<b>Superabrasive Wheels - Metal Bond</b>		
- 80, 100, and 120 grits	Dressing Stick	37C80-NV
- 150, 180, and 220 grits	Dressing Stick	37C150-KV
- 240 and finer grits	Dressing Stick	37C220-KV
<b>Conventional Vitrified Wheels - Vitrified Bond</b>		
- 46 grit and finer and M grade and softer	High Performance Dressing Stick	Norbide
	Conventional Dressing Stick	37C24-SVK

### TECH TIP

#### Dressing Diamond and cBN Wheels

- 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

### Offhand 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 JT246 dressing stick – an extra coarse grit silicon carbide for dressing conventional vitrified wheels – is firmly held and adjusted by the knurled control.



SIZE (D x L)	SPEC.	STD. PKG.	TIER: BETTER	
			PRODUCT #	PART #
<b>Offhand Grinding Wheel Dressing Stick and Holder</b>				
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5	JT246	614636 <b>87900</b>
10 Overall	Dressing Stick Holder	5	H6	614636 <b>87895</b>

### Norbide High-Performance Sticks

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

SIZE (T x W x L*)	STD. PKG.	TIER: BETTER	
		SPEC.	PART #
<b>High Performance Long Life Stick</b>			
1/4 x 1/2 x 3	5	Norbide	614636 <b>10148</b>

\* Thickness x Width x Length