

## DRESSING STICKS

MACHINE USED



### CATEGORY DEFINITION

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

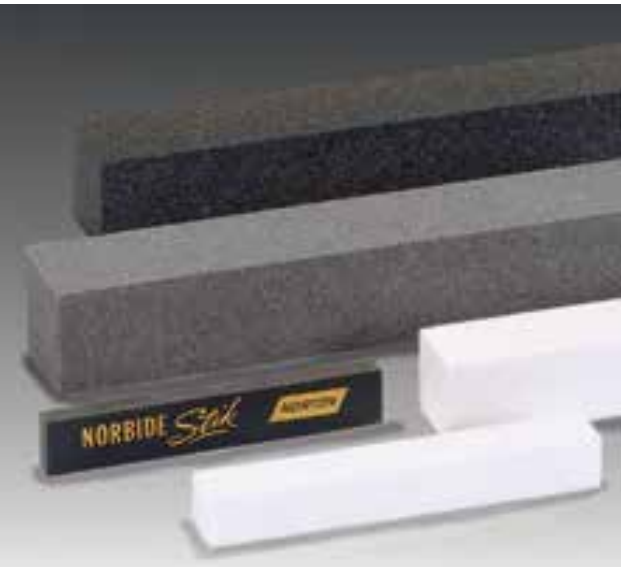
**APPLICATIONS:** Truing, cleaning, and dressing diamond, cBN, and conventional abrasive grinding wheels

**SIZE RANGE:** Thickness/Width/Diameter: 1/4" – 1"  
Length: 3" – 8"

**GRIT RANGE:** 16 – 400

**ABRASIVE GRAIN:** Aluminum Oxide, Boron Nitride, Silicon Carbide

**SHAPE:** Square, rectangular, and round



### 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.

#### VITRIFIED DRESSING STICKS

	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



### Norbide High Performance Sticks

For offhand truing and dressing of medium grit, soft- and medium-grade 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.

### AVAILABILITY

SIZE (T x W x L*)	STD. PKG.	SPEC.	TIER: BETTER	
			BRAND:	Part #
			Norton	
<b>High Performance Long Life Stick</b>				
1/4 x 1/2 x 3	5	Norbide	61463610148	
* THICKNESS X WIDTH X LENGTH				

## TECHtip

### 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

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### Rubber Finishing Sticks

These sticks are used for manual or mechanical honing on machines where they are mounted in holders or fixtures. Intended for use where precision dimensional limits and grade controls are required, such as die polishing.

#### AVAILABILITY

TIER: **BETTER**  
 BRAND: Norton

SIZE (T x W x L)	MIN./STD. PKG.	SPEC.	PART #
<b>Rubber Finishing Sticks</b>			
1/2 x 1/2 x 6	5/20	57A120-B2RR	61463610608
1/2 x 1 x 6	5/20	57A120-B2RR	61463610609

### Blank Stock FastTrack Made-to-Order Microabrasive Superfinishing Sticks



Superfinishing blank stock encompasses a wide range of different specifications. These blanks can be finished to your dimensional requirements within two weeks from the date that the order is received at Norton Customer Service. Small lots, for test purposes, can be express shipped.

APPLICATIONS	ABRASIVE TYPE – BOND	GRIT RANGE	TREATMENT TYPE
<b>Superfinishing / Finishing and Dressing</b>	NLA – V	240 – 1200	Sulfur, Wax
	NMVC – VCA		
<b>Honing</b>	NSA – V	54 – 220	
	SG – VS		
	SGG – VS1		