



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
 Grit range: 16 – 1200
 Abrasive grain: Aluminum Oxide, Boron Nitride, Silicon Carbide
 Shape: Square, rectangular, and round
 Machine Used:



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
Superabrasive Wheels - Resin and Vitrified Bond		
- 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
Superabrasive Wheels - Metal Bond		
- 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
Conventional Vitrified Wheels - Vitrified Bond		
- 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.

TIER: **BETTER**
 BRAND: Norton

SIZE (T x W x L*)	STD. PKG.	SPEC.	PART #
High Performance Long Life Stick			
1/4 x 1/2 x 3	5	Norbide	61463610148

* Thickness x Width x Length

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

Vitrified Dressing Sticks

Aluminum Oxide (White)

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

Silicon Carbide (Black)

Coarse grit (16 - 46) and hard-grade (R and harder) sticks are used for dressing conventional vitrified wheels. Finer grit and softer grades are used for dressing diamond wheels.

TIER: BETTER			
BRAND: Norton			
SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
Vitrified Dressing Sticks – Aluminum Oxide			
3/8 x 3/4 x 4	5	38A150-IVBE	61463639635
1/2 x 1/2 x 4	5	38A220-HVBE	61463610555
1/2 x 1/2 x 6	5	38A150-IVBE	61463610303
	5	38A220-HVBE	61463610103
1/2 x 3/4 x 4	5	38A60-LVBE	61463610415
1/2 x 1 x 4	5	38A180-IVBE	61463699705
3/4 x 3/4 x 4	5	38A60-LVBE	61463610440
	5	38A80-MVBE	61463610362
	5	38A90-LV	61463639632
	5	38A150-HVBE	61463610291
	5	38A150-IVBE	61463610368
	5	38A220-HVBE	61463610290
3/4 x 3/4 x 8	5	38A220-HVBE	61463610280
1 x 1 x 6	5	38A150-HVBE	61463610405
	5	38A150-IVBE	61463610453
	5	38A220-HVBE	61463610406
1 x 1 x 8	5	38A120-IVBE	61463610390
	5	38A150-IVBE	61463610455

Vitrified Superfine Sticks

For dressing superabrasive wheels.

TIER: BETTER			
BRAND: Norton			
SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
Vitrified Superfine Sticks – Aluminum Oxide			
1 x 1 x 6	5	PCD Coarse - 400 grit	61463647865
	5	PCD Fine - 800 grit	61463647867
1 x 1 x 8	5	NSA320-H8V	61463610597
Vitrified Superfine Sticks – Silicon Carbide			
1/2 x 1/2 x 6	5	NMVC320-J5VCA	61463610599
	5	NMVC400-J5VCA	61463650324
1 x 1 x 6	5	NMVC320-J5VCA	61463610605
	5	NMVC400-J5VCA	61463650450

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.



TIER: BETTER				
BRAND: Norton				
SIZE (D x L)	SPEC.	STD. PKG.	PRODUCT #	PART #
Offhand Grinding Wheel Dressing Stick and Holder				
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5	JT246	61463687900
10 Overall	Dressing Stick Holder	5	H6	61463687895