



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 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 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	
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. Norbide and Boron Carbide 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.	BEST		BETTER	
			PART NO.	SPEC.	PART NO.	
HIGH PERFORMANCE LONG LIFE STICKS						
1/4 x 1/2 x 3	5			Boron Carbide		61463629472
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



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.

AVAILABILITY

TIER: **BETTER**

SIZE (T X W X L)	STD. PKG.	SPEC.	PART NO.
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
		38A220-HVBE	61463610103 <i>B</i>
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 <i>B</i>
1 x 1 x 8	5	38A120-IVBE	61463610390
		38A150-IVBE	61463610455

B = BEST SELLER; PERFORMS WELL IN A VARIETY OF APPLICATIONS FOR MANY SATISFIED CUSTOMERS

Vitrified Superfine Sticks

For dressing superabrasive wheels.

AVAILABILITY

TIER: **BETTER**

SIZE (T X W X L)	STD. PKG.	SPEC.	PART NO.
VITRIFIED DRESSING STICKS – SILICON CARBIDE			
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
		37C150-LV	61463610375
3/4 x 3/4 x 6	5	37C20-SVK	61463610459
1 x 1 x 6	5	37C24-SVK	61463610462
		37C24-TVK	61463610354
1 x 1 x 8	5	37C46-RVK	61463610466
		37C80-NV	61463610393
		37C150-KV	61463610438
1 x 1 x 6 (retail carded)	5	37C220-KV	61463610398
		S/C Medium Grit	07660710466
1 x 1 x 8	5	37C20-SVK	61463610469
		37C24-SVK	61463610471
1 x 2 x 8	5	37C16-TVK	61463610482
		37C24-TVK	61463610485
2 x 2 x 8	5	37C24-SVK	61463610490
VITRIFIED ROUND DRESSING STICKS – SILICON CARBIDE			
1/2 x 6	5	37C24-SVK	61463610371
1 x 6	5	S/C Ex-C (JT276)	61463687905

AVAILABILITY

TIER: **BETTER**

SIZE (T X W X L)	STD. PKG.	SPEC.	PART NO.
VITRIFIED SUPERFINE STICKS			
1/2 x 1/2 x 6	5	NMVC320-J5VCA	61463610599
		NMVC400-J5VCA	61463650324
1 x 1 x 6	5	NMVC320-J5VCA	61463610605
		NMVC400-J5VCA	61463650450
1 x 1 x 8	5	NSA320-H8V	61463610597

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.

AVAILABILITY

TIER: **BETTER**

SIZE (D X L)	SPEC.	MIN./STD. PKG.	PRODUCT NO.	PART NO.
OFFHAND GRINDING WHEEL DRESSING STICK AND HOLDER				
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5/10	JT246	61463687900
10 Overall	Dressing Stick Holder	5/10	H6	61463687895





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

SIZE (T X W X L)	MIN./STD. PKG.	SPEC.	PART NO.
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RUBBER FINISHING STICKS

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. Small lots, for test purposes, can be express shipped.

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