

**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**

		TIER: BETTER	
		BRAND: Norton	
SIZE (T x W x L*)	STD. PKG.	SPEC.	PART #
<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



### 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**  
 BRAND: Norton

SIZE (T x W x L)	STD. PKG.	SPEC.	PART #	
<b>Vitrified Dressing Sticks – Aluminum Oxide</b>				
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	
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	

AVAILABILITY

TIER: **BETTER**  
 BRAND: Norton

SIZE (T x W x L)	STD. PKG.	SPEC.	PART #	
<b>Vitrified Dressing Sticks – Silicon Carbide</b>				
1/2 x 1/2 x 6	5	37C24-SVK	61463610285	
	5	37C100-LV	61463610201	
	5	37C150-KV	61463610205	
	5	37C150-LV	61463610206	
	5	37C150-MV	61463610207	
	5	37C220-KV	61463610214	
3/4 x 3/4 x 6	5	37C150-LV	61463610375	
1 x 1 x 6	5	37C20-SVK	61463610459	
	5	37C24-SVK	61463610462	
	5	37C24-TVK	61463610354	
	5	37C46-RVK	61463610466	
	5	37C80-NV	61463610393	
	5	37C150-KV	61463610438	
	5	37C220-KV	61463610398	
	1 x 1 x 6 (retail carded)	5	S/C Medium Grit	07660710466
	1 x 1 x 8	5	37C20-SVK	61463610469
		5	37C24-SVK	61463610471
1 x 2 x 8	5	37C16-TVK	61463610482	
	5	37C24-TVK	61463610485	
2 x 2 x 8	5	37C24-SVK	61463610490	
<b>Vitrified Round Dressing Sticks – Silicon Carbide</b>				
1/2 x 6	5	37C24-SVK	61463610371	
1 x 6	5	S/C Ex-C (JT276)	61463687905	

### Vitrified Superfine Sticks

For dressing superabrasive wheels.

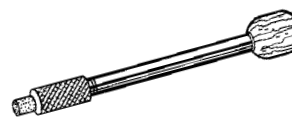
AVAILABILITY

TIER: **BETTER**  
 BRAND: Norton

SIZE (T x W x L)	STD. PKG.	SPEC.	PART #
<b>Vitrified Superfine Sticks – Aluminum Oxide</b>			
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
<b>Vitrified Superfine Sticks – Silicon Carbide</b>			
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.



AVAILABILITY

TIER: **BETTER**  
 BRAND: Norton

SIZE (D x L)	SPEC.	MIN./STD. PKG.	PRODUCT #	PART #
<b>Offhand Grinding Wheel Dressing Stick and Holder</b>				
1/2 x 6 Round	Silicon Carbide Extra Coarse Grit Round Dressing Stick	5/10	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**  
 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		