

# CHOOSING A DRESSING STICK

Choosing the right dressing stick for your grinding wheel application involves considering several factors to ensure optimal performance. Reference the resources below to assist you with choosing the right stick for your application.



## THE DRESSING STICK FORMULA

**EXAMPLE: 2A 180 F8**

MATERIAL TYPE	GRIT	BOND / HARDNESS	STRUCTURE
1A: Brown Aluminum Oxide 2A: White Aluminum Oxide 8A: Pink Aluminum Oxide 2C: Black Silicon Carbide 3C: Green Silicon Carbide	Standard grit sizes: 80, 100, 120, 150, 180, 220, and 320. Custom fine grits are available up to 1200.	Hardness is controlled by the type of bond & the ratio of bond to grain.  SOFT ←         → HARD E F G J	Concentration of grain for a specific area determines structure.  CLOSED ←       → OPEN 8 9 10

## WHAT STICK DO I USE?

**RULE OF THUMB:** Match the stick to the type of wheel being conditioned/dressed (grit & type). Sticks are designed to be used wet with water or coolant.

WHEEL TYPE	Vitrified Diamond	Resin Bond, Diamond, & CBN	Metal Bond Diamond	Glass Pencil Edging, Metal Bond
STICK	Aluminum Oxide or Silicon Carbide	Aluminum Oxide or Silicon Carbide	Aluminum Oxide or Silicon Carbide	Aluminum Oxide

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