

# Superabrasive dressing guidelines



## Improved performance & consistent grinding results

- Exposes new crystals for improved performance
- Increased life of the wheel
- Allows for consistent performance with each pass
- Customized dressing solutions available by request

# “CITCO aluminum oxide dressing sticks expose the superabrasive crystals for improved performance, while improving the life of the wheel”

## SUPERABRASIVE WHEEL DRESSING GUIDELINES

- Superabrasive wheels must be dressed after trueing to expose the superabrasive crystals by eliminating the glazed, closed surface resulting from the trueing operation or normal wheel use
- To achieve maximum results dress the superabrasive wheel on the machine with a CITCO aluminum oxide dressing stick
- For best results the dressing sticks should be soaked in coolant for at least 5-10 minutes before they are applied (may be done dry, but for best results use wet)
- To dress the wheel apply slight hand pressure against the trued surface with the coolant off or at a slight drizzle to create a slurry effect
- The slurry effect will aid in exposing the diamond
- When the operator is able to feel the dressing stick “melt like butter”, this is a signal that the wheel’s surface is open enough to begin grinding
- CAUTION: do not over stick the superabrasive wheels as it will result in excessive wheel wear
- CITCO dressing sticks can be used on CNC grinders as well as manual grinders

Fives designs & supplies CITCO Tools customized dressing solutions. CITCO dressing sticks are designed to open, sharpen, condition or expose new crystals within the superabrasive grinding wheel to ensure maximum performance throughout the life of the wheel. This wide range of solutions is backed by over 75+ years of tooling expertise and a professional team of application engineers.

## SELECTING THE CORRECT DRESSING STICK

- Define the grit size of the crystal in the superabrasive wheel being dressed
- Select a dressing stick that is 1 to 1-1/2 times finer than the grit size of the superabrasive grinding wheel

### Example:

If the superabrasive grinding wheel is 150 grit, it is recommended to use a 220 grit dressing stick

If the superabrasive grinding wheel is 500 grit or finer, it is recommended to use a dressing stick with a 500 grit

## CITCO TOOLS STOCKED ALUMINUM OXIDE DRESSING STICKS

Catalog number	Size	Grit
WLDS150	3/8" x 3/4" x 4"	150
WLDS220	3/8" x 3/4" x 4"	220
WLDS500	3/8" x 3/4" x 4"	500
WLDSL150	1" x 1" x 6"	150
WLDSL220	1" x 1" x 6"	220
WLDSL500	1" x 1" x 6"	500

\* Other sizes and/or grits can be special ordered by request



### CONTACT US:

**Fives Landis Corp. (CITCO Tools)**  
7605 Discovery Lane - Concord Twp., OH 44077 - USA  
Tel: +1 440 709 0700 - Fax: +1 440 709 0710  
Email: citcoinfo@fivesgroup.com

**Fives Landis Corp. (Gardner Abrasives)**  
481 Gardner Street - South Beloit, IL 61080 - USA  
Tel: +1 815 389 2251 - Fax: +1 815 389 5024  
Email: gardnerinfo@fivesgroup.com

[www.fivesgroup.com](http://www.fivesgroup.com)