



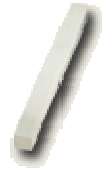
How to Use Inland Dressing Sticks

A dressing stick is used to redress sintered wheels and restore their cutting ability. As long as you can see sintered material, you should be able to dress it. Make sure that you are using the correct stick for your wheel grit.

- Use the Inland White 240 Grit dressing stick, no 419998, on finer grit sintered wheels like 140 and 200. It can also be used on sintered saw blades and core drills.
- Use the Inland Brown 80 Grit Dressing Stick, no 419999 on coarse grit sintered wheels like 30, 60, 80, and 100 grit wheels
- Dressing sticks are for use in sintered products ONLY! Using them on single layer diamond tooling like plated and brazed products will quickly destroy those tools.

Using the White Fine Dressing Stick:

1. Soak it in water for about 20 minutes to get the abrasive material soaked through.
2. With the wheel mounted on your machine and coolant running on the wheel, bring it up to full speed. Poke the end of the stick into the wheel and work it back and forth across the face of the wheel a few times then remove the stick and turn the machine off.
3. Your wheel should now cut noticeably better.



Using the Brown Coarse Dressing Stick:

1. Soak it in water for about 20 minutes to get the abrasive material soaked through.
2. With the wheel mounted on your machine and coolant on the wheel, bring it up to full speed. Poke the end of the stick into the wheel and work it back and forth across the face of the wheel a few times.
3. Turn the power off. Continue to poke the end of the stick into the wheel working it back and forth to slow the wheel to a stop. This helps to remove any broken or badly rounded diamond.
4. Repeat steps 2 through 4 three or four times.
5. With the wheel now running at full RPM and coolant running on the wheel, poke the end of the stick into the wheel and work it back and forth across the face of the wheel a few times then remove the stick and turn the machine off. This cleans out any matrix left by the stop and dress method performed in steps 1 -4.
6. Your wheel should now cut noticeably better.

