

Ripley Machine has been an industry leader for grinding services since the 1950s. Our operators in our grinding department have an average of 20 years in grinding. We utilize the experience to offer the highest of quality grinding service available. We couple this high quality with a true commitment to service and competitive pricing. Our lead times and prices are often significantly better than our competition. We also utilize various logistics avenues that enable us to serve the entire United States as well as portions of Canada. Please feel free to call or email us for assistance on your next grinding project. Our shop is ready to serve any of your grinding needs with our experienced staff and high quality equipment!

### **Internal Grinding**

- ◇ We are able to grind straight or taper bores
- ◇ We can grind parts with a bore diameter between .625" and 9" with a length up to 7"
- ◇ For jobs requiring a ground taper bore, we use a corresponding taper gage (typically customer supplied although we have qualified vendors to provide if necessary). We follow a standard procedure to determine the gage standoff which determines the bore diameter
- ◇ We record stand off dimension and a copy of the bluing strips (used to ensure correct taper) for each part ground
- ◇ For jobs requiring a straight taper bore, we typically use certified dial bore gages set with gage blocks and a height gage. When lead time and quantity warrant we will purchase a specialized ring gage to our bore gage

### **Thrufeed Centerless Grinding**

- ◇ Thrufeed is best utilized on higher quantities where the ground diameter is the largest diameter (no shoulders). The part is then able to pass through the grinding zone.
- ◇ Parts with a diameter as small as .063" and up to as big as 2-1/2"
- ◇ Tolerances as close as .0003" and surface finishes better than 8 Ra
- ◇ For high production jobs, we have the ability to utilize automatic feeders and air gaging

### **Centerless Bar Stock Grinding**

- ◇ Capability to grind bars up to 1" diameter at lengths up to 14' long.
- ◇ Experience in grinding numerous materials including: tool steel, stainless steel, aluminum, Hastelloy, brass, copper, plastic and many more
- ◇ We often grind bar stock for Swiss machines to fit an existing collet and/or guide bushing to save cost and lead time of new work holding. We also grind bar stock to finish diameter to save cycle times. This includes grinding to major diameters for parts with an external thread.
- ◇ We are able to grind customer supplied material or use one of our qualified vendors to purchase and supply the material ourselves.

### **Infeed Centerless Grinding**

- ◇ When your part has a geometry that does not allow for it to pass through the grinding area, infeed centerless grinding can be used to essentially "plunge" grind the diameter to size. This method is also useful on parts that are out of round or for small quantities.
- ◇ Our infeed grinder can grind up to 4" in diameter and up to 6" long. We can hold tolerances to .0003" and surface finishes better than 8 Ra

### **Center Grinding**

- ◇ We have the capability to grind between centers with our CNC Grinder
- ◇ We can grind parts up to 20" long and up to 3" in diameter
- ◇ We have the ability to grind multiple diameters to ensure concentricity between them