

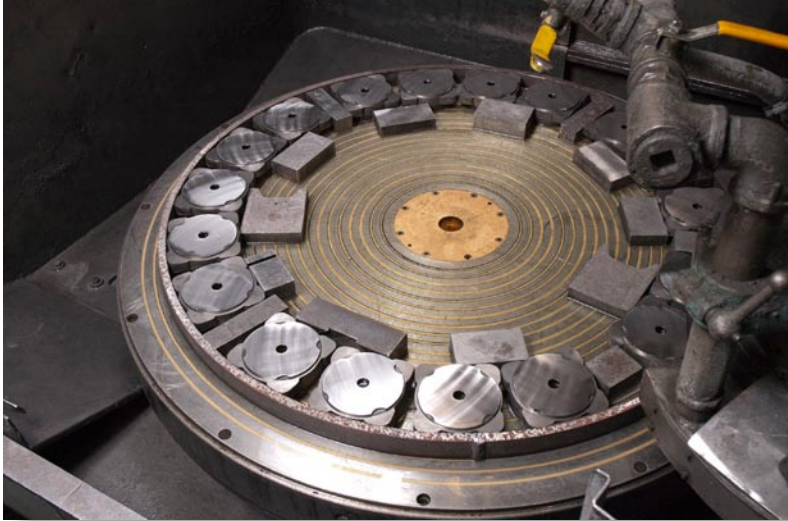
**WHAT'S  
NEW**

# GRINDLINES

2012

**SIXTH  
EDITION**

## IMPROVED ROTARY SURFACE GRINDING



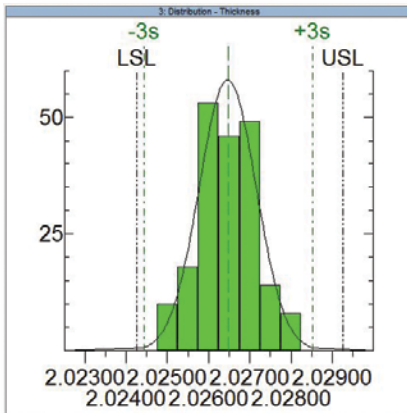
Unfinished surface and after our modified precision rotary surface grinding on a cast iron part.

Columbia Grinding applies new technologies to an old machine and process. Our modified Blanchard style grinder can now hold  $\pm .0002$  inches across a 42 inch rotary table. This application of newer styles of abrasives gives way to many grinding possibilities. A second machine was added because of increased demand.



## PUSHING THE LIMITS ON FLAT HONING / FINE GRINDING

This job held  $\pm .0015$  mm (.00006 inches) consistently with our new enhanced grinding process.



4: Statistics - Thickness	
N(nk)	198
Mean	2.026472
s(n-1)	0.000682
s(RBar)	0.000450
USL	2.02925
LSL	2.02425
Cpk	1.65
Ppk	1.09
Cp	1.85
Pp	1.22

Columbia continues push on high tolerance jobs with advances in Fine Grinding / Flat Honing . Note the SPC graph from a recent run of parts showing a 1.6 CPK. We held a 1.4 to 1.9 CPK over the entire order ( 25,000 + ). This being categorial ( 15 different sizes ) in nature added to the challenge.



The Flatwork Specialists™

ISO 9001: 2008

**WE WILL TAKE YOUR  
FLATNESS CHALLENGE!**

7411 South 10th Street  
Oak Creek, WI 53154  
(414) 762-7320 • FAX (414) 762-7544

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

[sales@columbiagrinding.com](mailto:sales@columbiagrinding.com)