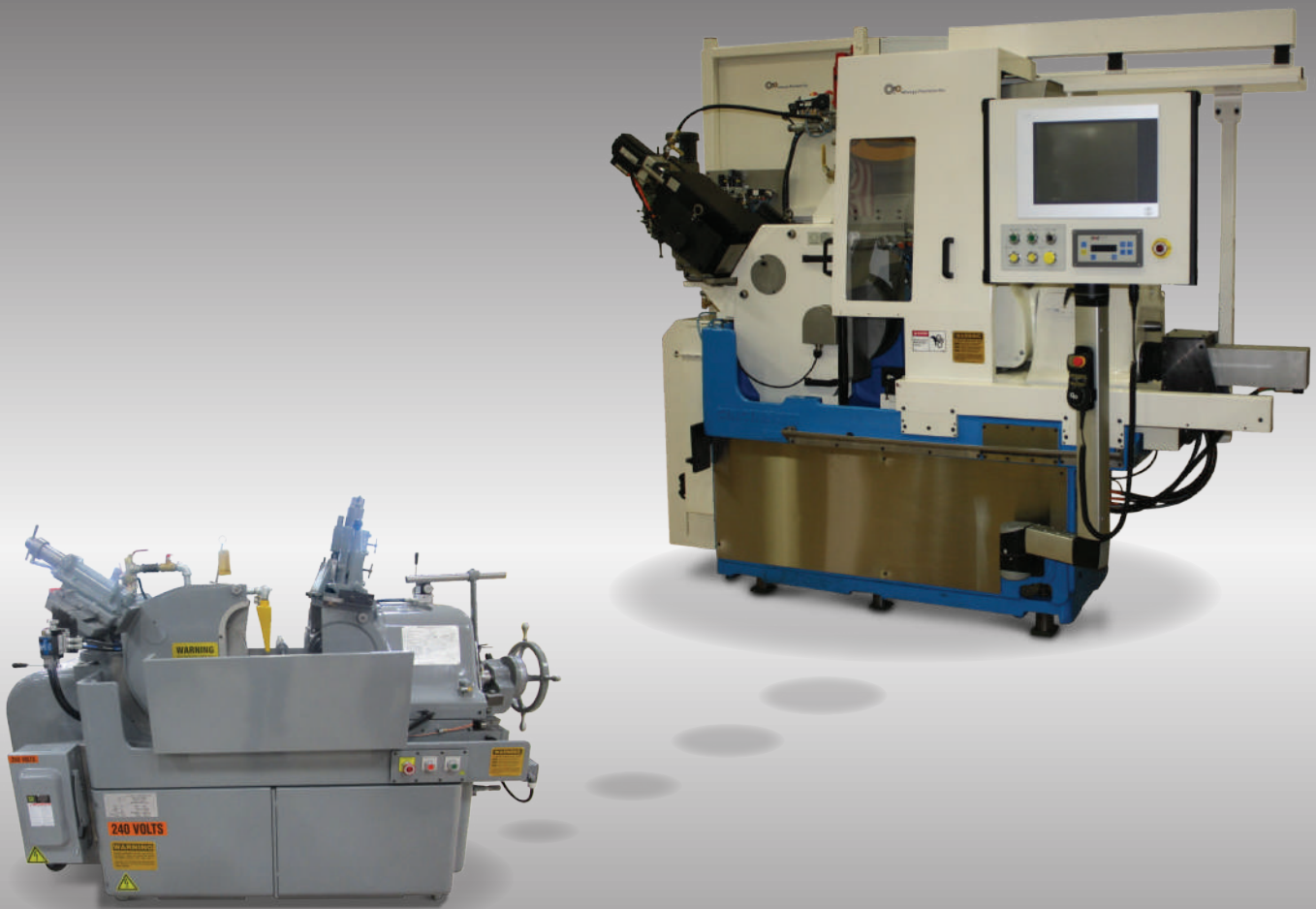




# Allways Precision

Centerless. Precision. Endless Solutions.



## Centerless Grinders

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Remanufacturing • Parts • Sales • Service • Training

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Allways Precision specializes in remanufacturing, buying, and selling of Cincinnati centerless grinders. We have the largest inventory in the world of Cincinnati centerless models and parts.

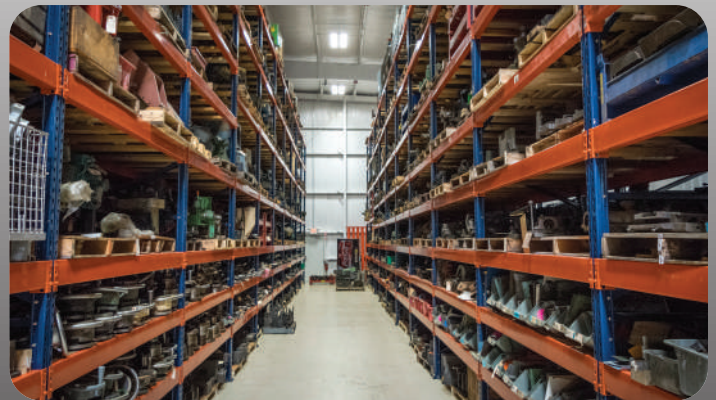


# Company Overview

Founded in 1992, **Allways Precision's** 75,000 square foot facility is located just 35 miles Southwest of Chicago. Our experienced team of professional engineers, master machine builders, and service technicians are ready to meet all of your centerless grinding needs.



After more than 25 years **Allways Precision** continues to be the preeminent source for all Cincinnati centerless machines, parts, tooling and service. Leading the industry by merging the latest technology with master craftsmanship to ensure the highest standards are achieved.



Whether you need a complete machine, replacement parts, or some setup training let us help you meet your needs.

# Our Process

Each of our remanufactured grinders is completely stripped down to a bare casting, painted with epoxy enamel, and then reassembled with new components to our customers specification. All of the ways are ground, hand scraped, and fitted to exacting tolerances. All of the spindles are coated and precision ground back to size with bearings hand scraped for optimal fit, ensuring the highest performance and greatest longevity. This is how **Always Precision** builds a machine to hold sub-micron tolerances.



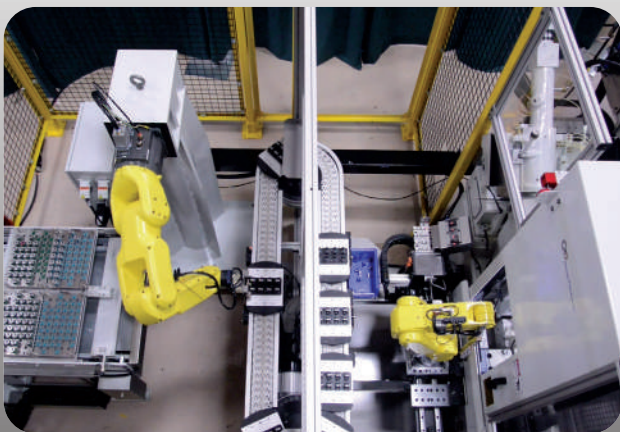
For applications where a remanufactured machine isn't required, we also offer partially rebuilt and certified machines. **Always Precision** can rebuild or replace components as necessary to save you money.



Contact us today to let our Applications Engineers understand your requirements and come up with a Complete Grinding Solution for you.



# The Complete Grinding Solution



## Buy or Sell Equipment

- Remanufactured grinders
- Partially rebuilt grinders
- Certified or inspected
- Trade-ins and core swaps

## Modular CNC Upgrade Packages

- Dual infeed/thrufeed slide control
- Precision 2-axis dressers
- Grinding and Regulating wheel drives

## Parts / Segments / Assemblies

- 3,000+ new parts in stock
- 10,000+ used parts in stock
- Complete assemblies on exchange
- Spindles, beds, and dressers

## Service & Training

- Dedicated service personnel
- Same-day/Next day service available
- On-site and classroom training

## Automation

- Infeed and thrufeed automation
- Full turnkey solutions
- Lights out capability
- Robotics

## Centerless Grinders

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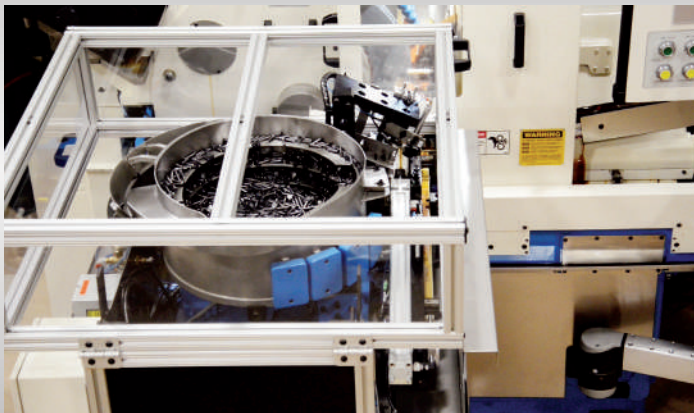
# Allways Precision

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## Infeed Automation

Maximize your production capability!

Vibratory or centrifugal feeders can run a broad range of parts with easily adjustable tooling.



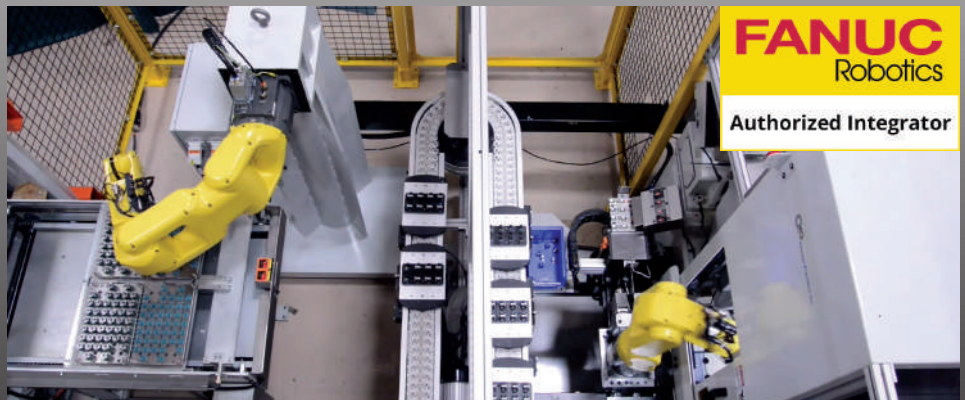
Gantry style loaders offer excellent flexibility along with the capability to run multiple parts simultaneously.



No matter what your part configuration is, we have an automation solution to fit your needs. Let us help improve your productivity today!

FANUC 6-axis robots offer total flexibility for the most demanding automation applications.

Gauging, cleaning, deburring and other secondary operations can be incorporated.



**FANUC**  
Robotics  
Authorized Integrator

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



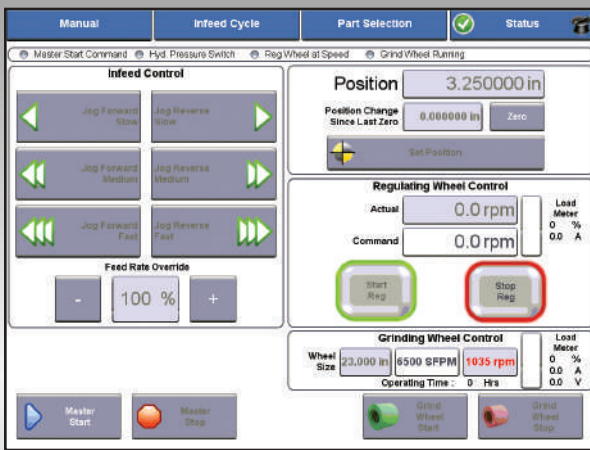


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## CNC Infeed Grinder Control

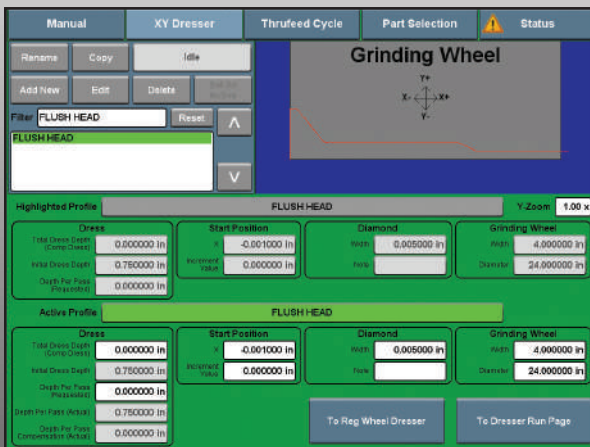
For more than 20 years Allways Precision has been perfecting the AP Grind software that powers all of our CNC grinders.



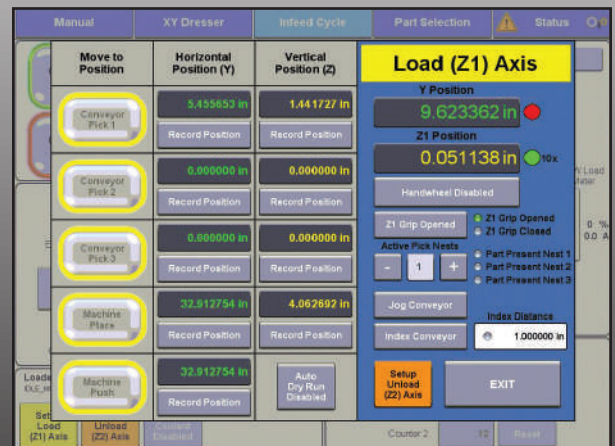
Requiring no G or M code knowledge, the completely conversational control requires no specialized training to operate.



Part recipes, notes, and setup information can all be stored and recalled by part number.



When equipped with a 2-axis CNC dresser, precision form grinding becomes as easy as pushing a button.



Controls for automation are integrated into the machine HMI to allow for quick and easy setup or changeover.



# Allways Precision

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## Thrufeed Automation

Maximize your production capability!

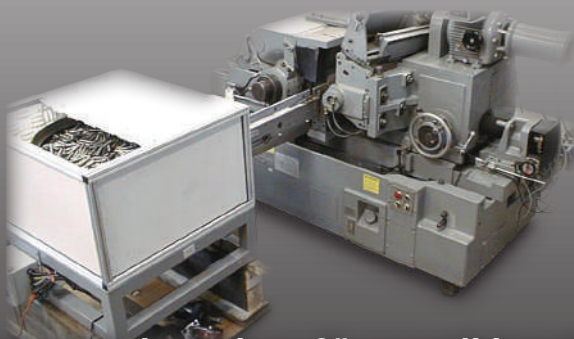
Our large diameter shaft loader can feed parts up to 48" in overall length and a 2" maximum diameter.



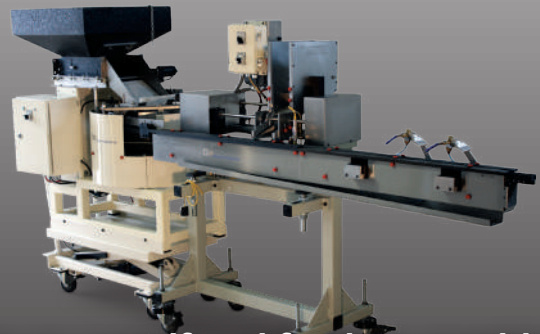
For smaller parts, our small diameter shaft loader can load parts up to 24" in length and up to 1" in diameter.



No matter what your part configuration is, we have an automation solution to fit your needs. Let us help improve your productivity today!



For parts less than 3" overall length, vibratory or centrifugal feeders combined with a conveyor can be an excellent solution for achieving high feed rates.



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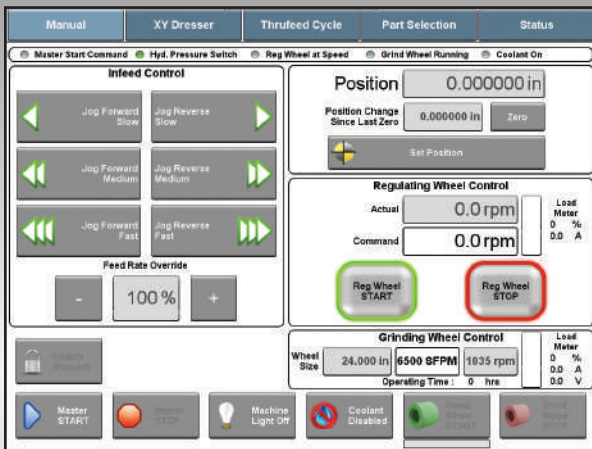


# Allways Precision

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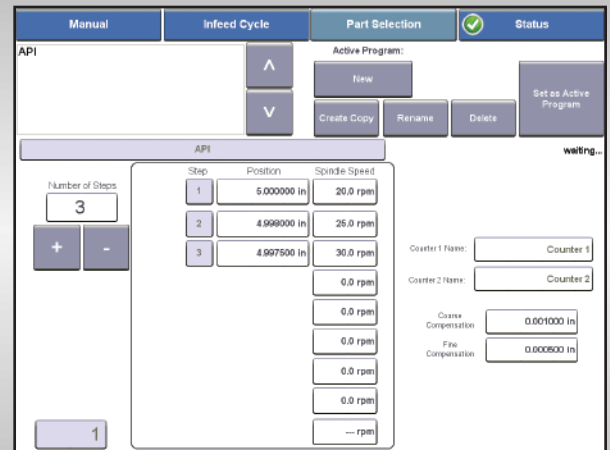
## CNC Thrufeed Grinder Control

For more than 20 years Allways Precision has been perfecting the AP Grind software that powers all of our CNC grinders.

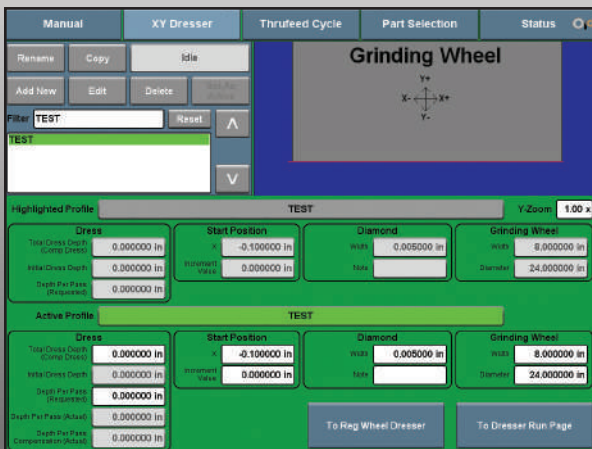


The intuitive AP Grind software requires no specialized training and little experience to operate efficiently.

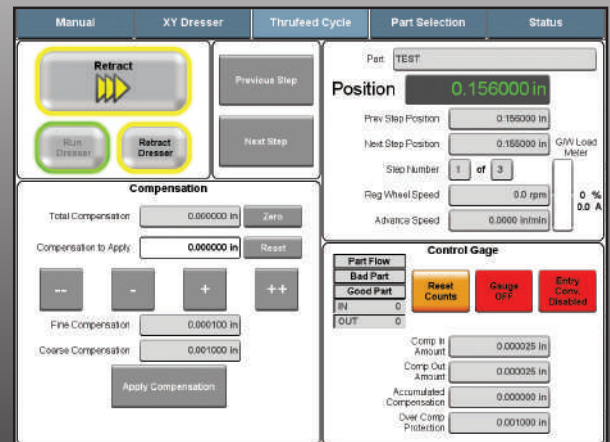
Part recipes, including multiple passes and feed rates, can all be stored and recalled by part number.



When equipped with a 2-axis CNC dresser, the dressing frequency can be controlled by multiple variables.



Multiple gauging solutions can be used to provide real-time feedback to the grinder to improve process capability and reduce operator touch time.



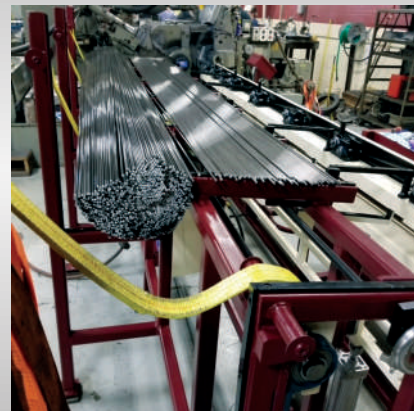


**Centerless. Precision. Endless Solutions.**

# **Bar Grinding Automation**

**Maximize your production capability!**

For high volume bar grinding, our bar tables offer the highest productivity available by completely automating the process. With the optional bar return system, running multiple passes becomes as easy as loading once.



We also supply a full range of other bar feeding systems and fixtures to fit all of your bar grinding needs. Let us help you improve your productivity today!



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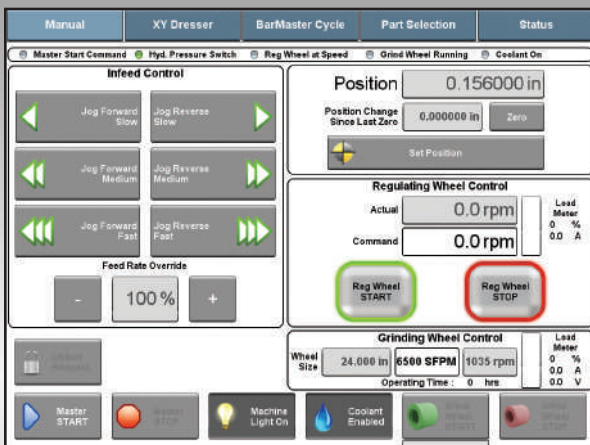


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## CNC Control for Bar Grinding

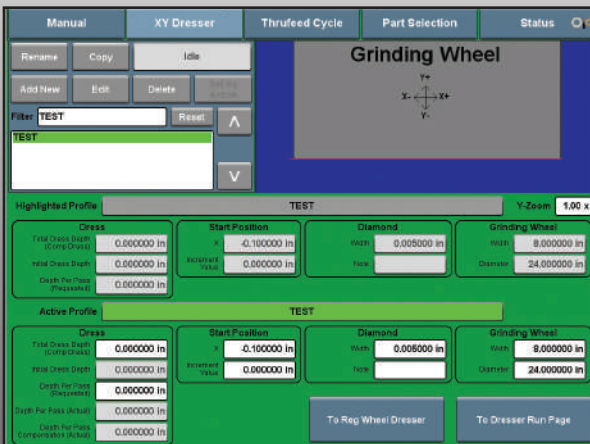
For more than 20 years Allways Precision has been perfecting the AP Grind software that powers all of our CNC grinders.



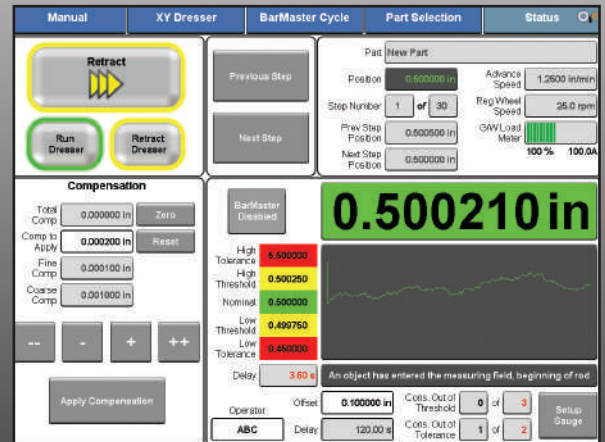
Featuring an easy to use graphical interface, the control requires no specialized training to operate.



Part recipes, including multiple passes and feed rates, can all be stored and recalled by part number.



When equipped with a 2-axis CNC dresser, the dressing frequency can be controlled by multiple variables.



BarMaster™ is our proprietary closed-loop gauging system that allows for higher precision bar grinding and improved grinder efficiency.





# Allways Precision

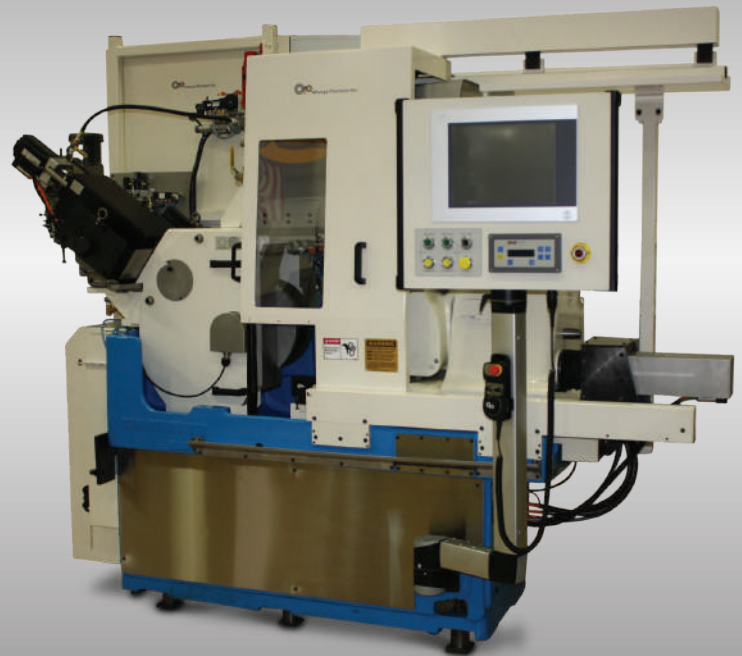
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Remanufactured

## Cincinnati #20M

### Machine Specifications

Optimum Diameter Capacity . . . . . .040" to 1.5"  
Max Diameter Capacity . . . . . .Up to 4"  
Grinding Wheel Diameter . . . . . .20" or 24"  
Grinding Wheel Width . . . . . .Up to 8"  
Max. Grinding Wheel Speed . . . . .10,500 SFPM  
Regulating Wheel Diameter . . . . .12" or 14"  
Static Stiffness (Upgraded) . . . . . 275,000 lbs.  
Approximate Weight . . . . . . 8,500 lbs.



### Common Applications

- Hand Feed Infeed Grinding
- High Volume, Automated, or Complex Form Infeed Grinding
- Small Diameter Bar Grinding



# Allways Precision

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## Available Upgrades

- CNC Infeed/Thrufeed Control
- CNC Grinding Wheel Dresser
- CNC Regulating Wheel Dresser
- Servo Regulating Wheel Drive
- Complete Containment Guarding
- Variable Frequency Drives
- Automatic Fire Suppression
- Lights Out Automation

And More!

## Centerless Grinders

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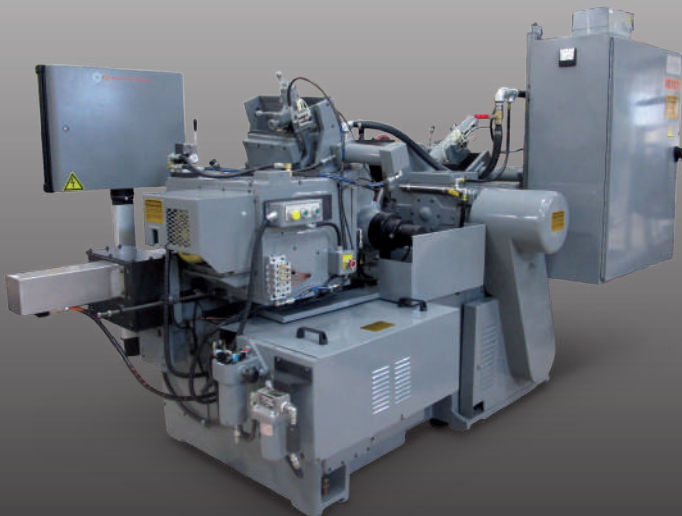
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Remanufactured

## Cincinnati 220-8

### Machine Specifications

Optimum Diameter Capacity . . . . .	.040" to 2.5"
Max Diameter Capacity . . . . .	Up to 4.75"
Grinding Wheel Diameter . . . . .	20" or 24"
Grinding Wheel Width . . . . .	Up to 10"
Max. Grinding Wheel Speed . . . . .	10,500 SFPM
Regulating Wheel Diameter . . . . .	14"
Static Stiffness . . . . .	425,000 lbs.
Approximate Weight . . . . .	15,500 lbs.



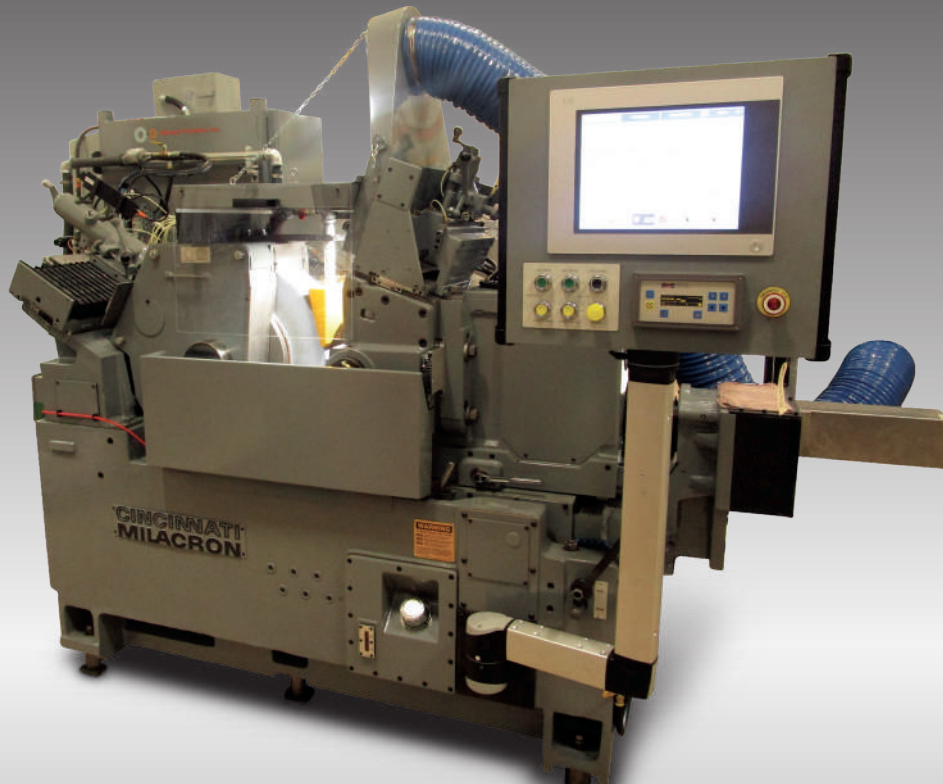
### Common Applications

- Heavy Stock Removal  
Hand Feed Infeed Grinding
- Multiple Part Infeed Grinding
- Thrufeed Shaft Grinding





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## **Available Upgrades**

- CNC Infeed/Thrufeed Control
- Complete Containment Guarding
- Variable Frequency Drives
- Servo Regulating Wheel Drive
- CNC Grinding Wheel Dresser
- CNC Regulating Wheel Dresser
- Automatic Shaft Loaders
- Multiple Part Loading Automation

**And More!**

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Remanufactured

## Cincinnati 230-10 Twin Grip

### Machine Specifications

Optimum Diameter Capacity . . . . .	.040" to 2.5"
Max Diameter Capacity . . . . .	Up to 4.75"
Grinding Wheel Diameter . . . . .	24"
Grinding Wheel Width . . . . .	Up to 10"
Max. Grinding Wheel Speed . . . . .	10,500 SFPM
Regulating Wheel Diameter . . . . .	14"
Static Stiffness . . . . .	1,000,000 lbs.
Approximate Weight . . . . .	16,500 lbs.



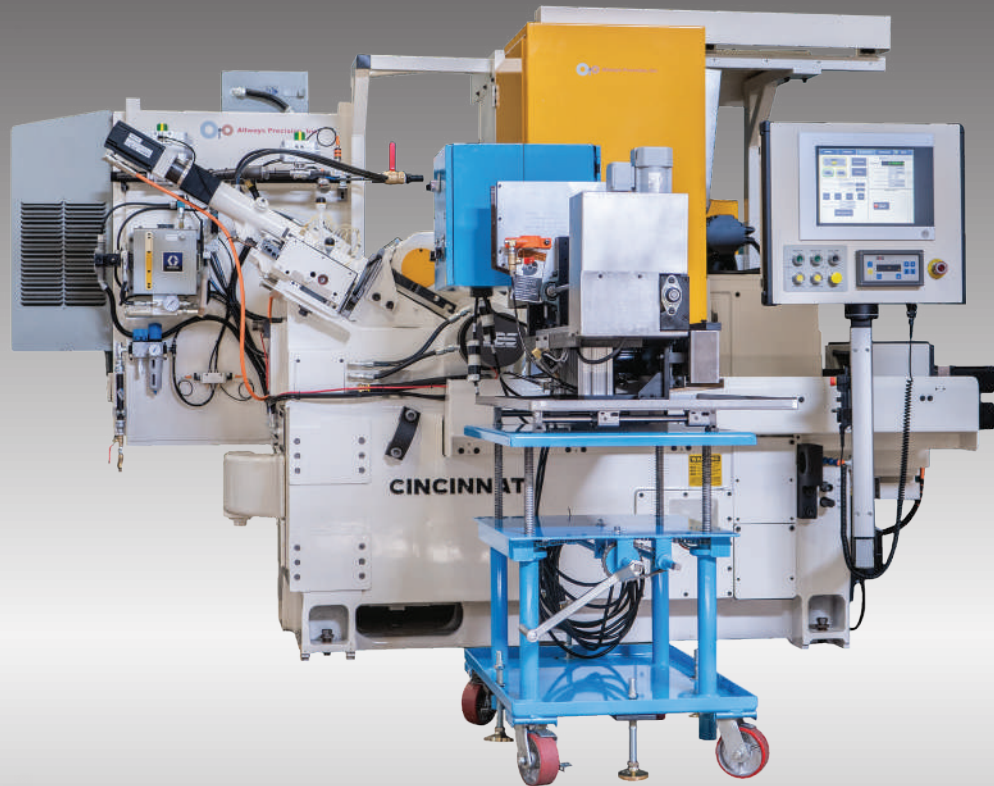
### Common Applications

- High Precision Infeed or Thrufeed Grinding (0.000050" or 1um Tolerance)
- Multiple Part Infeed Grinding
- Thrufeed Shaft Grinding



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## Available Upgrades

- Dual Servo CNC Infeed/Thrufeed
- Extra Heavy Duty End Bracket
- Servo Regulating Wheel Drive
- Variable Frequency Drives
- Complete Containment Guarding
- 2-axis CNC Grinding and Regulating Wheel Dressers
- Automatic Bar Feeding System

And More!

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Remanufactured

## Cincinnati 340-20

### Machine Specifications

Optimum Diameter Capacity	0.5" to 3"
Max Diameter Capacity	Up to 6"
Grinding Wheel Diameter	24"
Grinding Wheel Width	Up to 20"
Max. Grinding Wheel Speed	10,500 SFPM
Regulating Wheel Diameter	14"
Static Stiffness	1,000,000 lbs.
Approximate Weight	22,000 lbs.



### Common Applications

- Infeed Grinding Long Parts (up to 20" length)
- High Volume or Heavy Stock Removal Thrufeed Grinding
- Large Diameter Bar Grinding







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## Available Upgrades

- CNC Infeed/Thrufeed Control
- Main Motor Upgrade (up to 100HP)
- BarMaster™ Gauging System
- Automatic Bar Feeding Systems
- Heavy Duty Worm Drive for Regulating Wheel
- Variable Frequency Drives
- 2-axis CNC Dressers

And More!

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