



President's message

Carbide Processors, Inc.

Northwest Research Institute, Inc.

Newsletter April, 2007

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sales@carbideprocessors.com www.carbideprocessors.com

Need Special Tools?

Over the last 25 years we have gotten to know a lot of people in the tool industry. We have a nice little sideline helping people find special tools, tools they don't ordinarily buy.

In addition we know who makes the really top end stuff. If you are a small shop and need help selling something you don't ordinarily sell we would be happy to help you.

Any and all kinds of carbide

Insert tooling

Special grades of inserts

Any and all kinds of braze alloy

Diamond and CBN wheels

(Really beautiful wheels)

Saw plate

Finished tools

Saw blades

Router bits

CNC router bits

Indexable tooling

Bandsaws

Hand files

Industrial magnets

Coolants.

Coolant filter systems

Drill bits

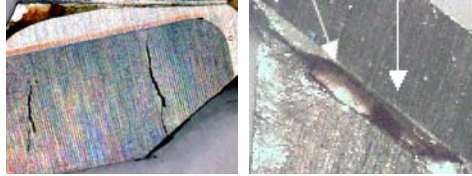
No guarantees on what we can find but we are pretty good. (Emily and Jacque are anyway.)

Our **Super C** grade is winning friends all over. It costs about the same as ordinary carbide but it is much harder to break and stays sharper much longer.



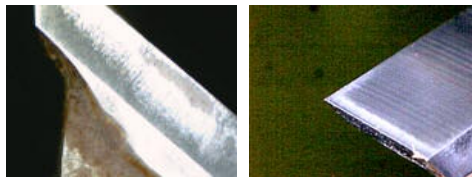
There are many ways to measure tip life see P. 3 for more information on this.

Inspect Saws Before Running



Heat cracking from grinding (left) and alloy balls between steel and carbide (right)

And after running



Here are two pictures showing damage from corrosion

If you have any of these problems then just call and we will help you.

Filtering Straight Oil Coolants



We now have a filter system that filters straight oil coolants. Above is our CP 2020 which filters tight oil coolant very well. It is also available as a wall mount unit.

Finished Saws With Cermet II® Tips From Cal – Saw

Call Cliff Gordon (503) 580 -3253

We are very proud that we can now offer finished saw blades with Cermet II® tips from California Saw & Knife.

Cliff has been selling our advanced grade tips and is well aware of the difference they can make. Over the years we have referred folks with problems to Cal –Saw and know how good they are at solving problems. We have been in their plant and are very impressed by their equipment and people. (Hi, Alistair.)

Our advanced grades are very popular because they work extremely well. We have had many requests from people for finished saws and from saw makers for permission to use our tips. We're willing to work with most folks but working with Cal Saw was a real easy decision because of our long relationship and their excellent reputation. (See P. 2)

Cermet II® Tips From Paul Duclos at Peerless

Paul Duclos 503 753-5302



Besides having a new granddaughter Paul is a highly respected member of the saw community. If you have heard him speak or had him solve a problem for you then you know why. Paul is doing as many are doing and that is helping his customers slowly and carefully test Cermet II® tips.

Cermet II® Cuts A Fat Hog In Sandy, Chinese Plywood.



We have a couple places using our Cermet II tips in sandy, Chinese plywood. This is just what it sounds like. It is cheap plywood from China that is highly abrasive.

Cutting a fat hog means things are going really well. If you butcher a fat hog you are going to have good eating. If you are biblical then think about killing a fatted calf. Pretty much the same meaning.

In this case it means that folks are building saws with our advanced tips and winning new customers.

Cermet II busts the BeetleBuster

I had dinner with three guys from a huge carbide company. They wanted to know what I was doing. It turns out that our Cermet II grades are running better than twice as long as their Beetle buster grade of carbide.

The pine beetle is killing limber in Canada and moving into the US rapidly. Beetle killed lumber is much harder than ordinary lumber.



We buy carbide scrap about \$5.50 /

A little carbide scrap makes a fair amount of money. Shipping is cheap since you can use postal service "any weight" boxes. We get it, weigh it and write a check in 30 days. Let us know how you want the check made out; company or individual. There is no need for a 1099 since this is a sale of material. Having said that, we are careful about who we buy from. People are having scrap stolen so sell yours now. It is easier to put \$1,000.00 in your pocket than 200 pounds of scrap.

Cal Saw & Cermet II® tips

We are being very careful about this. Part of the reason is to protect our patents and trademarks and partly because our tips don't work to their full potential on bad saws.

There are at least five parts to successful saws
Material being cut
Equipment doing the cutting
Design of the saw blade
Quality of the manufacture of the blade
Materials used to make the blade

Why Cal – Saw

1. They are an extremely good company. They are not the only good company in the industry but there are none better.
2. We have a long relationship with Cal-Saw.
3. Cal-Saw has an unequalled history of developing new sawing technology. Our advanced tips with their stainless steel saw blades will make incredible blades.
4. Cal saw stepped up first with an agreement.

Legal Protection

Our Super C©, cermet and Cermet II© technologies are protected under various US patents and copyrights both issued and pending.

This gives us considerable rights such as the right to seize property made without our permission. This would include lumber cut in a mill as well as furniture made from that lumber. While seizure is unusual it is possible. Much more likely that we would be awarded treble damages.

In order to protect these rights we are only selling directly to end users or through approved distributors.

Why We Love Our Customers

Emily sent a message to a customer that his tooling was done and they were ready to make parts. She got this reply. "It's been 3 seconds since I read your message. Are they done yet?" The reason we love our customers is that he was kidding.

Disposing Of Filter Cartridges, Coolant Pillows, Etc.

Federally and in most states these are classified as used oil filters. Call your local waste facility or recycling center and ask about recycling used oil filters.

Typically they all are all treated the same way automobile oil filters are treated. In Washington you have to drain them, crush them and then you can throw them in the trash.

Oil Filters

These are federal guidelines and seem to apply pretty universally. Check with your recycler or waste hauler and see what they say.

Used oil filters from our systems are treated like used oil filters from cars about everywhere as near as we can tell but check locally to stay out of trouble.

"Drain it for 12 hours into a used oil container, crush it and then dispose of it in the trash. If metal cased it may go into metal recycling. It may also go into oil recycling depending on your oil recycler.

Oil filters and diesel fuel filters, except terne-plated ones used in some heavy duty vehicles, are not considered hazardous waste. Oil filters are managed like used oil when sent to an oil filter recycler. Most recyclers prefer that filters be drained as much as possible before going into the filter collection container. Since recyclers often charge less for containers of crushed filters, it may be cost-effective for shops with large volumes to crush the filters on-site."

Be sure the oil filter recycler actually recycles your non-hazardous oil filters as used oil and scrap metal. (Some companies pick up oil filters, but don't recycle them.) To put filters in the dumpster, puncture the anti-drain back valve or dome end, turn the filter upside down and hot-drain it for 24 hours (in other words, remove the filter from the engine and drain it while still warm). Or, crush the filter and hot-drain. Recycle the drained oil with other used oils (see Oil).

From James Wankel New owner of Jayrod

Millwrightca@shaw.ca

I was born and raised in Victoria BC,
on Vancouver island

When I was 16 a construction Foreman that always stopped into the service station I worked at asked me what I wanted to do with my life. Always an entrepreneur I said make a buck. He quickly straightened me out and said "Son , Nobody can ever take a trade from under your belt " At the time I was pondering the schooling I should take and shortly enrolled in a ELT program at College for a year. Even though that course never turned into a long career I realized that all knowledge is useful.

At the age of 20 and a very seasonal work in Victoria I looked north, I packed all I owned in the back of pickup and headed north. I cut my teeth doing construction work building a copper mine in the west coast mountains of BC. I started as a grunt and climbed the ladder within a year I was working for the mine. Within another 6 months I was indentured as a Millwright. In total I spent almost 7 years at the mine, In this time I managed to acquire my welding ticket also.

I decided that Prince George was the place for me and put in for a job with some Canfor Mills. Over the last 5 years with Canfor I received some great experience in the Canfor network. I worked at a saw mill, pulp mill and a sodium chlorate plant.

My last position with the chemical plant I enjoyed being part of a push for better reliability. I was part of instituting vibration analysis and maintenance software that improved reliability greatly. I also managed to take part in factory training and certification for Mechanical seals in Dallas Texas and a compressor technology course in Calgary.

I am always up for a challenge and If I don't have your answers I will surely find them.

We have a challenge in Western Canada. There is a changing of the guard so to speak. How we handle this change will determine how our industry will prosper and continue to support our future generations.

Gord Jarabek is very knowledgeable and I enjoy learning from him and I look forward to learning from my customers also. I am looking forward to working together with all of you for many years to come.

Thanks,
James Wankel

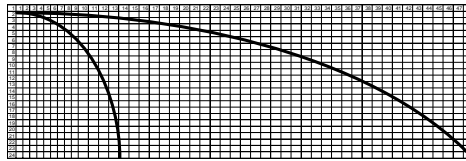
Measuring Tip Wear

Measuring Saw Performance

I spoke at the wood machining institute and Leonard Valdez, VP of Cal Saw, was in the audience. I talked about the results we were getting with our advanced grades and Leonard asked how we measured results. I covered some of the scientific ways and ended up saying that saw filers liked the results better. One of the many things we like about working with Cal Saw is their focus on success in the customer's terms.

How Carbide Wears

Typically, the more carbide wears the faster it wears.



Theoretically carbide wears as shown above with the standard carbide curve on the left and advanced carbide curve on the right. The longer they run, the farther apart the curves get. How long a material runs for you depends on what you are doing and what you mean by sharp.

Assume that that is a sharp tip on the left. As the tip wears the edges round. If you measure sharpness by edge radius then you reach a point where the tip continues to wear but it doesn't show up as indicated by the two tips on the right.



This is important because it explains why some people get 10 times the life and some get only twice. In our example of green lumber below they ran the blade until it was dull. In actual life many mills only run the blades 8 hours no matter what shape they are in.

Cermet II© Test – Blade Life

- 5 blades with standard C-4 carbide cutting 45 lb. single and double sided vinyl-laminated particle board
Cermet II - 15,088 meters / old grade - 6706 meters
225% as much run life
- KM-16 industrial saw cutting 101.6 mm x 152.4 mm (4" x 6") Green hardwoods, oak, hickory, maple and walnut using 11 blades with standard C-4 carbide
CermetII / 462 hrs / old grade - 40 hrs
1,155% as much run life
- 406 mm (16") 100 teeth cutting countertops
CermetII - 4 weeks / old grade - 1 week (4 times)
400% as much run life
- 406 mm (16") 80 teeth cutting MDF Board
CermetII - 10 days / old grade - 2 days (5 times)
500% as much run life
- 305 mm (12") 100 teeth TCG Miter cutting oak, Compressed Fiber Board, Plastic
CermetII - 154 hrs / old grade - 28 hrs (5.5 times)
550% as much run life
- 305 mm (12") 60 teeth cutting MDF, High Pressure Laminate (Formica)
CermetII - 56 hrs / old grade - 8 hrs (7 times)
700% as much run life
- G 1060A on Chop Saw cutting Particle Board and Pine Dowel Rods
CermetII - 48 hrs / old grade - 8 hrs (6 times)
600% as much run life

Newsletter helps an excellent filer Dave Snook

Emily took a message from Dave Snook saying our newsletter had really helped him. Because Dave is really good I was pretty proud of having helped him. Then Emily explained that Dave leads two Christian men's groups. Every week he sends a reminder to his groups and includes a really bad pun. He was running out until he got our last newsletter with 19 really bad puns in it.

Because I need all the help I can get to get into Heave here are some more puns. These are from John Schultz of Super Thin Saws. H

King Ozymandias of Assyria was running low on cash after years of war with the Hittites. His last great possession was the Star of the Euphrates, the most valuable diamond in the ancient world. Desperate, he went to Croesus, the pawnbroker, to ask for a loan. Croesus said, "I'll give you 100,000 dinars for it." "But I paid a million dinars for it," the King protested. "Don't you know who I am? I am the king!" Croesus replied, "When you wish to pawn a Star, makes no difference who you are."

Evidence has been found that William Tell and his family were avid bowlers. However, all the Swiss league records were unfortunately destroyed in a fire, and we'll never know for whom the Tells bowled.

A man rushed into a busy doctor's office and shouted "Doctor! I think I'm shrinking!!!" The doctor calmly responded, "Now, settle down. You'll just have to be a little patient."

Back in the 1800s the Tates Watch Company of Massachusetts wanted to produce other products and, since they already made the cases for watches, they used them to produce compasses. The new compasses were so bad that people often ended up in Canada or Mexico rather than California .. This, of

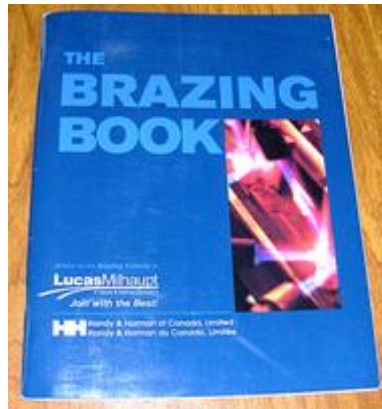
course, is the origin of the expression, "He who has a Tates is lost!"

An Indian chief feeling very sick, summoned the medicine man. After a brief examination, the medicine man took out a long, thin strip of elk rawhide and gave it to the chief, telling him to bite off, chew, and swallow one inch of the leather every day. After a month, the medicine man returned to see how the chief was feeling. The chief shrugged and said, "The thong is ended, but the malady lingers on."

A famous Viking explorer returned home from a voyage and found his name missing from the town register. His wife insisted on complaining to the local civic official who apologized profusely saying, "I must have taken Leif off my census."

A skeptical anthropologist was cataloging South American folk remedies with the assistance of a tribal brujo who indicated that the leaves of a particular fern were a sure cure for any case of constipation. When the anthropologist expressed his doubts, the brujo looked him in the eye and said, "Let me tell you, with fronds like these, who needs enemas?"

Get This Book - Free



This from Lucas Milhaupt and it is both free and really good.

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The following is from Mike West and I take no responsibility for it.

Will I live to be 80?

I recently turned 65 and had to choose a new primary care physician for my Medicare program. After two visits and exhaustive lab tests, he said I was doing "fairly well" for my age.

A little concerned about that comment, I couldn't resist asking him, "Do you think I will live to be 80?"

He asked: Do you smoke tobacco or drink alcoholic beverages?" "Oh no," I replied. "I don't do drugs, either."

"Do you have many friends and entertain frequently?"

"I said, "No, I usually stay home and keep to myself".

"Do you eat rib-eye steaks and barbecued ribs?"

I said, "No, my other doctor said that all red meat is unhealthy!"

"Do you spend a lot of time in the sun, like playing golf, sailing, hiking, or bicycling?"

"No, I don't," I said.

"Do you gamble, drive fast cars, or have a lot of sex?"

"No," I said. "I don't do any of those things."

He looked at me and said, "Then why do you care?"



We're always ready to help.



If we have to, we can wake up the old man for tech support

Filter Systems

Water Based Coolants
10" long housings
CP 2002 \$2038
Wall mount \$675

Straight Oil
20" long housings
CP 2020 \$2800
Wall mount \$1060

CP 2002 shown



Filter Life

Filter life is rated at one month between filter changes. We tested this and the minimum life we got was 22 days, double shift so figure 352 hours. If you are using one unit on two machines your life will be half this because you are doing twice the work. If you use one unit for four machines then figure a filter change once a week.

Filter Cake

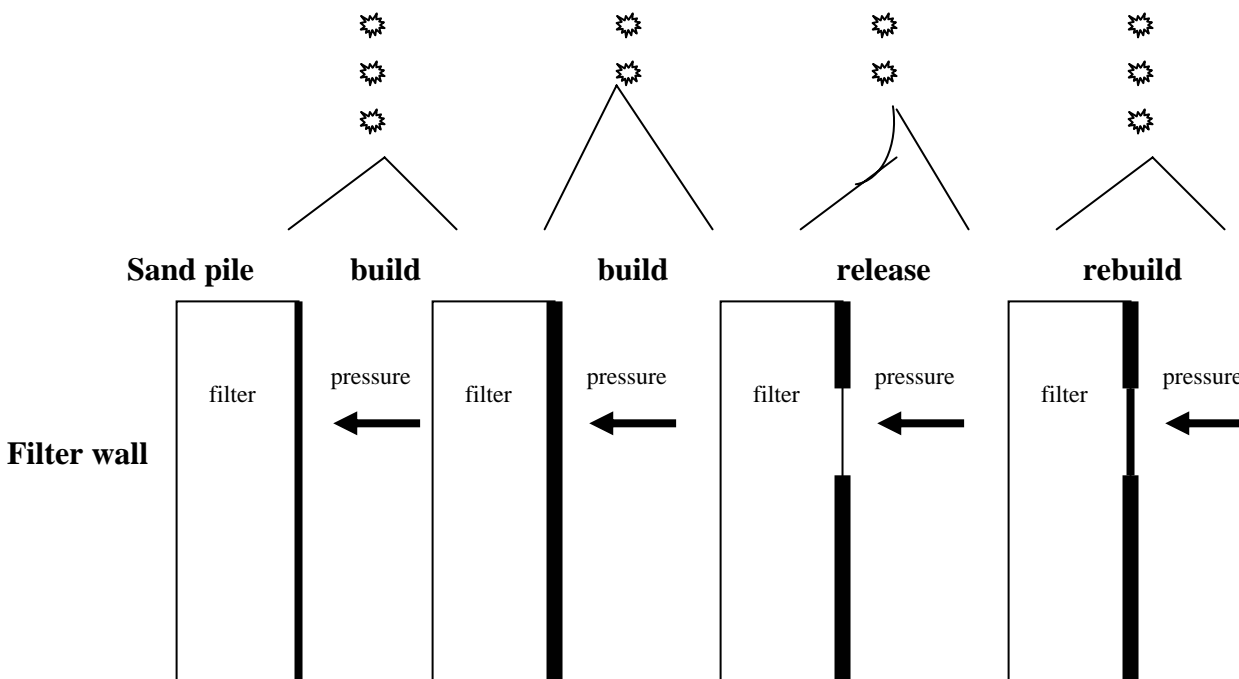
The material being filtered out will cake up and form a layer on the inside of the bag and the outside of the cartridge filter. How thick this cake becomes depends on how much tramp oil and grease you have in your coolant. Tramp oil is very different than grinding oil. It has bigger molecules and is thicker and gummier. The more tramp oil you have the thicker your cake will be.



This sump had a lot of tramp oil and grease so there is a thick cake. Your filter will probably not have this thick a cake if your machines are in good condition.

Catch and Release

Filters catch particles. A filter will catch a certain amount of particles and then release them. Think of piling up sand. You let it trickle out of your hand and form a pile. After a while part of the pile slides away and the trickle builds it back up again. The same thing happens with filters. They catch particles and after a while the pressure will force a bunch of materials through the filter. Then the pressure is relieved and the filters will catch particles again.



Navy Safety Photos

<http://safetycenter.navy.mil/photo/archive/>



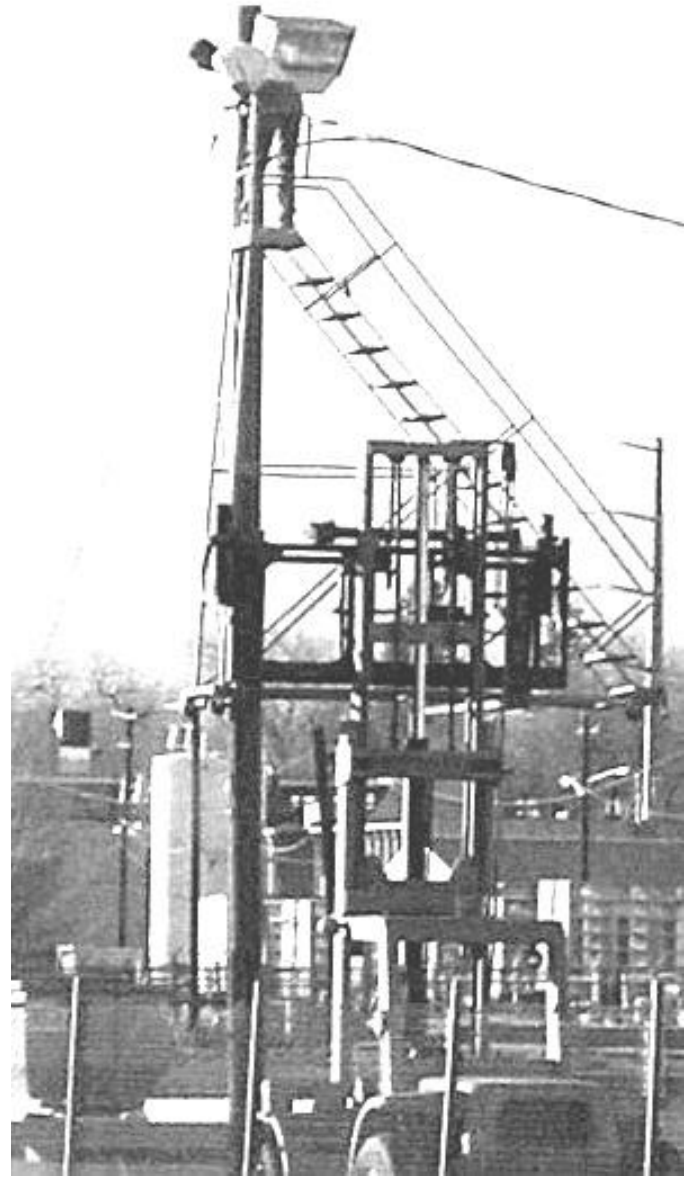
Hay bale scaffolding



Concrete blocks as scaffolding



Balanced on forks



Portable Stairs balanced on forklift



Truck rails as scaffolding

Disclaimers Protected Seller From Lawsuit Over Defects

R.O.W. Window co. v. Almetall Inc.
856 NE 2d 55
(III.App.2006)

From 1994 to 1998, R.O.W. Window Co., an Illinois company that manufactures insulated glass windows, bought spacers and corner keys for its windows from Allmetal Inc. During that period, the glass in thousands of windows failed due to a problem with Allmetal's products.

Because R.O.W. sold its windows to its customers with a 10-year warranty, it had to pay to replace the glass in the windows. Seeking to recover its replacement costs and its lost profits, R.O.W. sued Allmetal and charged the company with breach of the implied warranty of fitness for a particular purpose and breach of the implied warranty of merchantability.

Allmetal asked the Illinois trial court to grant judgment for it, arguing that it had disclaimed any implied warranties. Allmetal's product catalog included a notice, in capital letters, that stated: "The seller hereby expressly disclaims all warranties either expressed or implied, including any implied warranty of merchantability or fitness for a particular purpose." The disclaimer included language that limited Allmetal's liability for product defects to the purchase price of the product. In addition, Allmetal's standard invoice contained the same language, also in capital letters.

R.O.W argued that the disclaimers were not valid because they were not conspicuous. After the trial judge ruled for Allmetal, R.O.W. appealed to the Illinois Appellate Court that concluded the disclaimers were conspicuous.

In the catalog, the court noted, the disclaimers were contained in a section titled "Terms and Conditions of Sale," were set in capital letters, and set off in

a separate box. The court acknowledged that the disclaimer in the invoice was in small print, but noted that it was set in capital letters and was set off by open space above and below it. "The disclaimers were presented in a manner reasonably sufficient to draw attention to them," the court concluded.

R.O.W. also argued that the disclaimers were not binding because they were not part of the sales contract. However, the court stated that an implied warranty may be excluded by a course of dealing. R.O.W. was a customer of Allmetal for several years, the court noted, and during that period, all Allmetal's invoices and catalogs contained a conspicuous disclaimer of implied warranties. Thus, said the court, the disclaimers were made a part of the parties' agreements by the course of dealing.

Things found in logs (From the Internet)

- a side-harrow tooth.
- an old lead musket ball counted rings and it was about 100 yrs old.
- small metal box with a small quantity of gold dust and flakes in it.
- Coca-Cola bottle
- two 6-inch diameter by 8-inch long rocks, sitting vertically.
- nylon rope
- automotive-type water pump
- steel T-post
- four railroad spikes on one side of the log, three railroad spikes and an 8-inch lag screw on the other.
- animals (raccoons, squirrels, mice, cats, snakes and of course bee's honeycombs)
- disk blade with the 12-inch bolt holding it into the tree.
- 1/2-inch rebar
- metal-jacketed 50 caliber round.
- anvil

- horseshoes
- railroad spikes
- 18 electrical staples out of one place in a walnut log.
- sap spiles (to drain the sap for Maple syrup)
- a deer stand
- an ants' nest
- a 3/4" wire rope
- Shrapnel in a teak plank from ex-Rhodesia, now Zimbabwe.
- an old wrought iron fence straight through the middle.
- a mushroomed ball of lead about an inch in diameter
- nails
- insulators
- a metal roofing cap several feet long.
- a live 50 caliber shell.
- a spoon made from lead.
- a training grenade from WW1.
- a three inch hollow with an old five cent coke
- My helper was cutting up the branches of a felled Virginia pine when a section of about 8 inches burst into flames, producing a bright white light like magnesium burning. There was a water hose nearby, and he instinctively tried to flood the flames with water. It continued to burn - this was not pine resin. Finally, after repeated attempts to put it out, he decided to just pile the rest of the freshly cut, very green pine tree on top of the fire. Even with all the water from the hose, the flames ignited the whole tree into a blaze. I have a degree in biochem, and all I can figure is that some sort of explosives or fireworks, or a form of magnesium, etc. had been in a hollow, and the tree's new growth calloused over it.
- a live monkey from the local zoo



Not only a pretty face but also great customer service

Here is Emily, who is always perky and always happy to help customers. Emily's job is to help people find carbide, silver solder, filter systems and everything else we sell. If we can't supply you but we know who can we will refer you. No matter what you want we will work really hard to find it.

We Would Really Like It If You Bought From Us

We have great quality, great service, good prices and happy, helpful people to take your order. What more could you want?



And, if the nice approach doesn't work, we will wake up killer.



We have great tips and great pretinning.

This is good pretinning. It is ours and it is what you should be buying. Demand it (well, ask for it, anyway) wherever you buy carbide. If they won't ship to us we'll get it for you direct and save you time and money.

Carbide grades are like lumber

There are different kinds of lumber. If you are reading this you probably know that. You also probably know the differences in many of them. You also know that each stand of trees is unique and each tree and each board is unique.

Carbide is like that as well.

There is special carbide for corrosion, for MDF, for beetle killed Lodge Pole (Lodgepole in Canada) pine. If you are still using a common carbide can pretty well double triple or do much better than that for you.

Help this poor girl, please?



Call & sell scrap or just call her Jackie 800 346-8274



Do you want \$3,008.50?

We are paying \$5.50 per pound for scrap carbide. We wrote a check in January for \$3,008.50 to a filer for scrap carbide. He called originally and he knew he had some. He had no idea he had that much carbide or that it was worth that much money.

Need Bandsaw Help?

Blum's Saw Service, Puyallup, WA (800)225-8362 is really good. Call and ask for Wendy. Wendy is a nice guy who really knows what he is doing.

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