



## A Really Classy Person

### Neal Farnung of Saw & Specialty Corporation in Romulus, Michigan.

I had a customer e-mail me. He was looking for a saw blade inspection machine. I got looking around and eventually ended up talking to Neal Farnung of Saw & Specialty Corporation in Romulus, Michigan.

Mr. Farnung was incredibly generous with his time, information and offers of future help. I've never had the privilege of meeting him so I was just somebody calling out of nowhere. Yet, he gave me so much time and information that I was a bit embarrassed and afraid I was putting him out unduly.

I have said repeatedly that we really enjoy this industry, here at Carbide Processors, because of all the really great people in it. Mr. Farnung is certainly an excellent example of what we mean by that.

### Mike Hartman

#### Hartech Grinding Waterloo, Ontario

Mr. Hartman called the other day because he was interested in doing things better and someone told him I might be able to help him. This reminded me of two things. The saw filers who are a generation or two behind mine seem to be really bright. The second thing that came to mind was that I knew something that he didn't.

This brings to mind the upcoming Western Saw Filers meeting. It is a chance to meet other filers who may have a solution to your problem.

A lot of the old guys know each other and a young guy might feel left out. You don't have to. I'll be hanging around the Peerless booth. Come up and say hello and we'll let Peerless buy us a drink.

# Carbide Processors, Inc.

Northwest Research Institute, Inc.

## Newsletter August, 2011

3847 S. Union Ave. Tacoma, WA. 98409 (800) 346-8274

sales@carbideprocessors.com [www.carbideprocessors.com](http://www.carbideprocessors.com)

## We Have Carbide

Recent changes by one supplier in the carbide industry have caused a lot of disruption.

We get as many as several calls a day from people who are desperate to find carbide.

We saw this coming a year or so ago. We have greatly increased our carbide inventory here. We have worked with our suppliers to have them increase their inventory and to arrange for fast shipment to us or directly to our customers.

As always, we maintain a long list of carbide suppliers around the world.

If you need carbide please call 800-346-8274.

## Employee Problem



My daughter, and ace employee, Emily, claims she is pregnant and that she will need time off starting in September to have a baby. She has pretty convincing evidence so it might be true. (Those of you who also have daughters that can wrap you around their little finger understand why I am skeptical.)

We have Renee and Leslie to cover for her and I will help as well. We are not Emily but we will get it done. We just ask for a little patience.

## My New Hero

Dale Nostrand

Universal Saw Co., Inc.

Santa Fe Springs, CA



I have long noticed that it is unusual for a company to just do one thing well. Really good companies seem to do everything well.

We received 20 cases of carbide scrap from Universal Saw Company in California. Mr. Nostrand used medium flat rate boxes that cost \$10.85 each to ship. He had about 30 pounds of carbide in each one. The packaging was beautifully done. He used some scrap hardboard or thin plywood top and bottom inside the box. The scrap carbide was double bagged in gallon Ziplocs. The whole thing was cushioned with crumpled paper which works a lot better than peanuts.

We received these 20 boxes and two more later. All 22 were in great shape inside. As you can see, they were pretty beat up outside. The packaging was so well done that not a single tip was lost.

When you consider what 30 pounds of scrap carbide is worth and how little the flat rate box costs, and you can see why it makes sense to spend a little time with the shipping.

**Scrap Carbide \$8 per pound or more**  
- Carbide Scrap prices vary so call for a quote. 800 346-8274

## Simple Fixes



Plywood Truck Door



Electric Drill for Pancake Batter



Fixing a Pothole



Mercedes Hood Ornament from a Coat Hanger

## Ceratizit Seminars in Las Vegas

Ceratizit put on three seminars in Las Vegas. They were on: "The New Ceratizit Grades," "Grinding Carbide," and "Brazing Carbide without Stress." I think the industry very badly needs more education and I greatly applaud Ceratizit for putting on these seminars.

Attila Szucs of Advanced Superabrasives and Jana Spennes of Ceratizit were the presenters. Both speeches were interesting and had new information. Ms. Spenne's accent did make it somewhat hard to understand her.

Unfortunately, I can't tell you anything about the information delivered because Ceratizit considers it proprietary information.

I don't know how to describe the speeches exactly and I have been thinking about this for a couple weeks. I liked both speakers. Both speakers were very interesting and taught me things I didn't know.

Yet somehow I was left with the feeling that it could have been a lot better and I didn't know why. So I called Rudi Sommer of Radiac Abrasives. Rudy and I both give speeches to saw filer groups. I've heard Rudy speak and his speeches are excellent.

Rudy pointed out that he and I give speeches to audiences that want something specific. They want something they can take back and use immediately. I think Rudy is right. He and I make the assumption that the audience wants something brand-new that they can use now to make their jobs much easier and do much better work.

Again, Ceratizit is to be highly commended for doing this and the speeches given were a really good start. Now that they know the audience is likely to include people such as Ron Serwa of Vortex Tool, Gene Veening of Royce/AYR and Mike Lindsay of Eastside Saw / ISKA I am sure they will gear the presentations in that direction.

Notes:

1. I have never given a presentation that could not have been a lot better.
2. This was a very sophisticated audience. Giving a presentation to them really requires you to bring your "A" game.

Rudi Sommer  
Radiac Abrasives  
503 780-4221  
rudi.sommer@gmail.com

## 5 Pearls of Wisdom

1. Money cannot buy happiness, but somehow it's more comfortable to cry in a Mercedes Benz than it is on a bicycle.
2. Forgive your enemy, but remember the bastard's name.
3. Help a man when he is in trouble, and he will remember you when he is in trouble again.
4. Many people are alive only because it's illegal to shoot them.
5. Alcohol does not solve any problem, but then neither does milk.

## The Greatest Doctor in the World

Paul Smith, Smith Sawmill Service in Garrison Texas may have the greatest doctor in the world. His lovely wife, Debra, doesn't quite agree.

I went to the AWFS show in Las Vegas and was fortunate to have dinner with some of the boys from Peerless as well as Paul Smith and his wife.

Paul told a lot of great stories. My favorite was the one about him going to the doctor. I would try and tell it but I can't do it justice. Call Paul and have him tell it.

Best of all take them both to dinner and hear it that way. It is even better if you get Paul telling the story and Debra correcting him on it.

Smith Sawmill Service Garrison, TX  
800-598-6344



## Router Bit Breakage



These are router bits designed for plastic. They are really designed for CNC routers cutting ordinary plastic. The customer used them that way. The customer also used them in a handheld router to cut fiberglass which is where the problem arose.

The customer was good enough to send the router bits back so we could examine them. Here are three pictures of the router bits. You can see that the breakage on the router bits is practically identical from bit to bit to bit.



In my experience, when cutting tools suffer practically identical breakage, it generally means a misapplication of the tool or that the wrong tool was used for the job. (Same thing - just different ways of looking at it).

It could be a poor tool design where a weak spot was engineered or machined in.

I generally think of carbide defects as occurring randomly and look for different kinds of breakage in different parts of the tool.



Another thing to notice is the 'beach' (wave, tide, etc.) marks especially prominent on the right hand part. These marks are a series of lines one right after the other. You can see them marching up through the light gray area, right next to the dark black area. This shows that the router bits did not break in a single incident. Instead there is a series of dozens of tiny breaks or rips succeeding one another. Each beach line indicates a separate rip. There's a huge difference between a carbide router bit that snaps and a carbide router bit that has to be beaten apart with dozens of blows.

## Spokeo – New Web Site

There's a site called [www.spokeo.com](http://www.spokeo.com) that's a new online USA phone book w/personal information: everything from pics you've posted on Facebook or web, your approx credit score, home value, income, age, family member's names. Remove yourself by searching your name, find your page, highlight the URL and right click, select "copy", then go to the bottom right of the page & click on the Privacy link to remove yourself. You will have a chance to paste the URL in the first link. Copy & re-post so your FB friends are aware. The private info listed for me was extremely accurate.

## Super Thin Saws Now Management Owned

The management team at Super Thin Saws of Waterbury, Vermont is pleased to announce that we have purchased the portion of the company recently owned by UCT Coatings of Stuart, Florida. John Schultz, Rob Bisbee and Dave Strom now own 100% of the company. We are more committed than ever to giving our customers the very highest quality of product, service, and support.

## "Biodegradable" Does Not Mean "Safe"

We were offered a product to sell and we were assured it was 100% safe because it was biodegradable.

This is just not true. If anything, it may mean the opposite. Biodegradable means it breaks down naturally. This means it reacts very well with things in the environment. Safety in chemicals means that it does not affect people at all or that it affects people in a positive manner.

Nitroglycerin and cyanide are two chemicals that are very readily biodegradable. The formula for Nitroglycerin is  $C_3H_5N_3O_9$  which is carbon, hydrogen, nitrogen and oxygen. So nitroglycerin very rapidly breaks down into chemicals that are really good for life. Cyanide is  $CN$  and comes as Hydrogen Cyanide (HCN), a colorless gas, Sodium Cyanide (NaCN) or Potassium Cyanide (KCN). So cyanide is carbon and nitrogen which very rapidly breaks down and carbon and nitrogen are essential for life.

However nitroglycerin and cyanide gas are not considered safe.

**Following is a letter from the Washington State Department of Ecology explaining a bit about what biodegradable really means.**

"Dan Ferguson, Washington State Department of Ecology

Tom,

I just finished doing some research on your behalf. There is no legal definition of "biodegradable." I found this very good article that discusses what the definition could be if there was one.

<http://environment.about.com/od/eartht/alkcolumns/a/biodegradable.htm>  
<http://www.ftc.gov/bcp/gmrule/guides92.htm#G2>

The article basically states, while you don't legally have to prove a product is biodegradable, a company can still be sued by the FTC (Federal Trade Commission) or other parties if the "biodegradable" claim is "misleading and/or deceptive." I could help you determine this if you can get your hands on the product's MSDS sheet. Once I know the chemicals in the product, I would have a good idea on whether or not the product can break down readily. At the very least I could make sure the chemicals in it were not long lasting.

As for your second question, I realized after I tried to answer the black and white version, you may have meant "how do you certify a product to be biodegradable (or green) in Washington State or in the US?"

For the original question, I contacted Washington State Consumer Protection Agency as well as other Department of Ecology coworkers. The short answer is you do not need to certify a product in order to sell it. You do have to perform due diligence to make sure you're not selling a dangerous or inferior product as that could cause legal/business issues, but you don't have to go through a state or federal agency to sell something. The thing you do need to do is to make sure you can legally and safely ship or transport it. To make sure you can ship the product, you will need to check with the Post Master General (US Postal Service) and probably the Department of Agriculture as well. Their basic concerns will probably center around the toxicity and/or level of hazard the product may have.

As far as certifying a product as biodegradable or green in WA/US, there's a number of non-profit organizations that can do this, but the most recognized (most bang for your buck) is probably the EPA's DfE program (Design for the Environment). Now if I remember correctly the xxxxx xxxxxxx was not your product, but the company wanted to have it sold on your website or by your company.

Depending on how much they want to market their product as "biodegradable," they could pursue the DfE certification. More information about the DfE program is below and it might even be something your company may want to look into for other products if you're interested in finding other products that are DfE certified. As far as I know the DfE program usually certifies mostly consumer goods, but I would not be surprised if it starts branching out into the commercial sector as well.

<http://www.epa.gov/dfe/pubs/about/index.htm>  
<http://www.epa.gov/dfe/pubs/projects/formulat/label.htm>  
<http://www.epa.gov/dfe/pubs/projects/formulat/about.htm>

I hope that helps and if you have any other questions, feel free to contact me either by phone or email. I would be more than happy to help.

Regards,  
Dan Ferguson"

## MSDS Fraud

I ran across a case of what I believe to be a deliberately fraudulent Material Safety Data Sheet.

We were asked to sell a new product. We requested a material safety data sheet and any other information they had.

The MSDS only mentioned one chemical and said that the chemical was somewhere between 1% and 5% of the total.

I do not like this. According to OSHA an MSDS sheet is supposed to list all the chemicals that could harm a worker. You can get into a situation where even water could harm a worker if used improperly. There are a lot of chemical reactions where water is very dangerous. Perhaps the simplest to understand is water on a grease fire or a gas fire.

The one chemical mentioned wasn't too bad safety wise but they also mentioned that there was an organic catalyst in the formula. When you take the chemical mentioned and combine it with the right organic catalyst you get a pretty dangerous chemical created as a result. The chemical created is very volatile and has several health effects including cancer.

The manufacturer may have found a legal loophole. He may think that he can just list the two chemicals he adds without listing the dangerous chemical they create.

In any case, I definitely don't like it. I count on the MSDS sheets keep my staff, my customers and myself safe. When I speak on safety and health I often start out a speech by saying that it is a bad business practice to kill your employees. Then there is a nervous laugh from the audience. Then I explain that it is also a bad business practice to make your employees sick.

When I get an MSDS sheet I want to see all the chemicals listed. And I want an honest explanation of all the hazards. I then check the MSDS sheet I was given to see how accurate it is. Here is an address to the website I have found extremely helpful over the years.  
[Http://hazard.com/msds/](http://hazard.com/msds/)

## Exercise

1. If walking is good for your health, the postman would be immortal.
2. A whale swims all day, only eats plankton, drinks water and is fat.
3. A rabbit runs and hops and only lives 15 years.
4. A tortoise doesn't run, does nothing - yet lives for 450 years.



AND YOU TELL ME TO EXERCISE!

## **Cat Ordered To Do Jury Service**

A cat has been summoned to do jury service, even after his owners told the court he was "unable to speak and understand English".

Anna Esposito, wrote to Suffolk Superior Crown Court in Boston, US, to explain that a mistake had been made, but a jury commissioner replied saying the cat, named Tabby Sal, "must attend" on March 23.

Mrs. Esposito had included a letter from her vet confirming that the cat was "a domestic short-haired neutered feline."

Tabby Sal had been entered by Mrs. Esposito under the 'pets' section of the last census. "When they ask him guilty or not guilty? What's he supposed to say - miaow?" She said.

"Sal is a member of the family so I listed him on the last Census form under pets but there has clearly been a mix-up."

A website for the US judicial system states that jurors are "not expected to speak perfect English."

## **Protecting Sheep**

**John Schultz**

The Sierra Club and the U.S. Forest Service were presenting an alternative to the Wyoming ranchers for controlling the coyote population. It seems that after years of the ranchers using the tried and true method of shooting or trapping the predators, the Sierra Club had a "more humane" solution to this issue.

What they were proposing was for the animals to be captured alive. The males would then be castrated and let loose again. This was ACTUALLY proposed by the Sierra Club and by the U.S. Forest Service. All of the ranchers thought about this amazing idea for a couple of minutes. Finally an old fellow wearing a big cowboy hat in the back of the conference room stood up, tipped his hat back and said:

"Son, I don't think you understand our problem here... these coyotes... they ain't humpin' our sheep... they're eatin' 'em!"

The meeting never really got back to order. . .

### **Man and Animals – God's Plan**

On the first day, God created the dog and said, "Sit all day by the door of your house and bark at anyone who comes in or walks past. For this, I will give you a life span of twenty years."

The dog said, "That's a long time to be barking. How about only ten years and I'll give you back the other ten?"

So God agreed.....

On the second day, God created the monkey and said, "Entertain people, do tricks, and make them laugh. For this, I'll give you a twenty-year life span."

The monkey said, "Monkey tricks for twenty years? That's a pretty long time to perform. How about I give you back ten like the dog did?"

And God agreed.....

On the third day, God created the cow and said, "You must go into the field with the farmer all day long and suffer under the sun, have calves and give milk to support the farmer's family. For this, I will give you a life span of sixty years."

The cow said, "That's kind of a tough life you want me to live for sixty years. How about twenty and I'll give back the other forty?"

And God agreed again.....

On the fourth day, God created humans and said, "Eat, sleep, play, marry and enjoy your life. For this, I'll give you twenty years."

But the human said, "Only twenty years? Could you possibly give me my twenty, the forty the cow gave back, the ten the monkey gave back, and the ten

the dog gave back; that makes eighty, okay?"

"Okay," said God. "You asked for it."

So that is why for our first twenty years, we eat, sleep, play and enjoy ourselves. For the next forty years, we slave in the sun to support our family. For the next ten years, we do monkey tricks to entertain the grandchildren. And for the last ten years, we sit on the front porch and bark at everyone.

## **Paul Smith's Doctor**

This is the way I remember the story. It's a lot better if you hear Paul and Debra do it over a half hour but not all of you are in Texas so I will do the best I can. Remember that there are several different versions but this is the one I remember.

Debra Smith had Paul Smith check his blood pressure. It seems like it was some astronomical number, maybe 350 over 150. (There were different opinions on exactly what it was. This is just the way I remember it). Anyway Debra convinced Paul to see a doctor.

Paul went into the doctor and they start discussing his lifestyle. The doctor asked Paul about his drinking habits and Paul said that he drank Jack Daniels and Coca-Cola mixed 50-50. I remember him mentioning that he drank about 3 Liters of Coca-Cola a day. This would also have meant about 3 Liters of Jack Daniels a day.

The doctor hears this and decides it is a real chance to help Paul improve his health. So the doctor tells Paul to cut out the Coca-Cola and just drink his Jack Daniels straight or with water.

Now Paul can be a really funny guy but he's nobody's fool. He said "Yes Ma'am" to the lady doctor and went home to give Debra the good news. Somehow Debra was not as thrilled with the news as Paul was.

That's the way I remember it. I think there's some truth in this version but probably not very much. Call Paul.

# Cup-Wheel Grinding

By Dr. Jeffrey A. Badger

## *The Grinding Doc*

Cup-wheel grinding is a peculiar type of grinding as the wheel-workpiece contact geometry changes throughout the process.

After truing the wheel, grinding occurs on the face of the wheel as shown in (a). The forces on this face are extremely large, and the wheel takes a hell of a beating during the “break-in period”. Quickly, a taper develops (b) and grinding moves from the face of the wheel to the bottom of the wheel. Here the forces on the wheel are lower, and wheel wear is typically (but not always!) lower as the forces are distributed over a larger area.

Why does the wheel take a beating? It has to do with the contact area. Let’s say you have a rim width of 3 mm (0.12”) and a workpiece width of 5 mm (0.2”) and you take a depth of cut of 0.050 mm (0.002”). During the face-grinding break-in period, the contact area is  $\text{Area} = \text{depth of cut} \times \text{part width} = 5 \text{ mm} \times 0.050 \text{ mm} = 0.25 \text{ mm}^2$ . After break-in the contact area increase to  $\text{Area} = \text{rim width} \times \text{part width} = 3 \text{ mm} \times 5 \text{ mm} = 15 \text{ mm}^2$ . That’s 60 times more area to cope with the same material-removal, meaning 60 times the number of grits doing the same work.

So what does this mean? Here are some things to consider:

1) If you take different depths of cut – say 0.050 mm (0.002”) on one pass, then 0.025 mm (0.001”) in the next pass, the taper will develop based on the largest depth of cut. So here the taper will be 0.050 mm (0.002”) high, and when you take the 0.025 mm (0.001”) depth of cut, you’ll be using only half of the available wheel face. This is shown in (c). Then you’ll wear only on that face of the wheel and when you take the 0.050 mm (0.002”) depth again, you’ll be grinding partially on the face again. In other words, your taper will be inconsistent and messed up, and you’ll pay the price with a

rougher surface finish, more wheel wear and more frequent truing.

2) Consider whether you’re infeed only on the forward pass or on both the forward and back passes. If you’re infeed on both, you’ll develop a taper on both sides as shown in (d). Now your contact area consists of only half of the rim width, meaning more wheel wear.

Can you measure the taper? Sure. Just take a chunk of material and plunge the wheel axially (not radially) straight down into it. Then take that and look at the profile under a low-magnification microscope. You won’t see a perfect taper as shown in the diagrams, but you’ll see something close to it.

3) Consider how is the taper affecting surface finish. When the taper fully develops, your final part dimension is being formed by a line-contact at the end of the taper instead of an area-contact. This will mean a larger rougher surface finish. This brings me to point (4):

4) Can we dress that flat into the wheel to begin with? Let’s say you don’t rely on the break-in period to form your wheel, but rather you form it yourself. Now you can say, “I want to use 2.5 mm of my rim for rough-grinding and 0.5 mm of my rim for finish-grinding.” This is shown in (e). Here the forces on the wheel during rough-grinding are even throughout and you have a flat area to really polish off surface finish. Most truing stations will let you angle the wheel. Let’s say you want to take a consistent (never larger) depth of cut of 0.100 mm and use 2.5 mm of your rim for roughing (and 0.5 mm for finishing). Then a truing angle of  $\text{angle} = \arctan(0.1/2.5) = 2.3^\circ$ .

5) Am I grinding too timidly and generating lots of heat? Since the forces are so large during the break-in period when grinding on the small-area face, grinders will slow down their feedrate to avoid chipping and burning. However, once the taper breaks in, this slow feedrate hurts them, as now the forces on the bottom of the rim are too

small! (Remember how the area increased by a factor of 60?) That means that the grit penetration depth is too small. Tungsten-carbide is a combination of hard tungsten-carbide particles held in a soft cobalt matrix. When the grit penetration depth is too small, the grits don’t easily form a chip – the tungsten-carbide particles just get pushed around within the cobalt, leading to lots of rubbing and heat generation. This heat causes “diamond burn”, or graphitization of the diamond, and “bond burn”, or softening or burning away of the resin. This means excessive temperatures and excessive wheel wear.

The in-the-ballpark magic number here is one micron. When the grit penetration depth is much below one micron, we get lots of rubbing, heat generation, diamond burn and bond burn. When it’s around 1.5 micron, we get nice chip-formation. If it gets in the two- or three-micron range, we get “grit ripout”, where the forces on the grits are so large that the grits quickly rip out of the bond material before they’ve had a chance to do much work. How do you calculate it the grit-penetration depth? This is something I talk about in my grinding courses.

In other words, if you’re grinding like a wimp, expect lots of burn and wheel wear.

Those are five key points when doing cup-wheel grinding. Take a look at your grinding process and see how they fit in. If you make changes, implement them one at a time and see how they work out.

### **Dr. Badger's Background**

This is the same Dr. Badger who writes a full page column every month in Cutting Tool Engineering magazine.

He has worked with several people in our industries and is very highly regarded. He is willing to put on seminars and training sessions. If you would be interested in a seminar in your plant please contact Dr. Badger.

Jeffrey A. Badger, Ph.D.

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## Grinding Course

The next three-day High Intensity Grinding Course is scheduled for October 19-21 in Columbus, Ohio, hosted by Diamond Innovations.

Half the reason to attend the course is to get *The Book of Grinding* and *The Grinder's Toolbox*. *The Book of Grinding* is 1500 pages of hardcore grinding information presented in a straightforward, practical, down-to-earth and often funny way. Previous attendees tell me they refer back to it over and over for years after the course. Is it better to dress uni-directional or anti-directional? Check *The Book of Grinding*. Am I truing my resin-bonded diamond wheel correctly? Check out *The Book of Grinding*. How should I size my coolant nozzle and what flowrate do I need? It's in *The Book of Grinding*. Why isn't my cleaning nozzle removing loading? The most common mistake is given in *The Book of Grinding*.

The *Grinder's Toolbox* is an Excel spreadsheet with tabs for surface grinding, cylindrical-traverse grinding, cylindrical-plunge grinding, single-point and blade dressing, plunge-roll dressing, plunge-disc dressing, diamond truing, and cooling. Input your parameters and get hard-hitting advice from The Grinding Viking.

If you want to take control of your grinding operations in a steady, long-term and significant way, whether you're a grinder, a wheel salesman, or a machine builder, The High Intensity Grinding Course is the place to be.

Details at [www.TheGrindingDoc.com](http://www.TheGrindingDoc.com).

## Western Saw Filer's Educational Association Conference in September

September 16th and 17th at the  
Monarch Hotel in Portland, OR.

This year's workshops will be all bandsaws. It will cover bandmill alignment, bandmill maintenance, saw geometry and many other issues related to bandsawing. There will also be workshops on band wheel grinding and tooling.

Some of the most knowledgeable people in the industry will be presenting a series of workshops designed to address a wide variety of problems and solutions to those problems.

We encourage any and all sawmills to send their Saw Filers to this program. Dollar for dollar you will not find a more comprehensive one day workshop anywhere. For less than the cost of a consultant for a day you can send the whole Filing crew to these workshops. The information they bring back to the mill will pay dividends for years to come.

As always, Filers are welcome to invite their Management or Maintenance personnel to join them at the workshops.

For more information please contact Bill Saily at [billsaily@hotmail.com](mailto:billsaily@hotmail.com) or [bsaily@frontiernet.net](mailto:bsaily@frontiernet.net). Hope to see you all there.



### There will be Free Food And Beverages plus Door Prizes

"Hi Perry. I tried to be more careful in my proofreading this month."

## How the Convention Works (In case you have never been)

This is a really friendly group and a good chance to meet fellow filers as well as new vendors. If you don't know anyone ask for Mike West or Bill Saily. They will be happy to see you and will introduce you.

Friday night is a social night. There is a free buffet for everyone, filers and vendors. Each vendor has free drink tickets. Vendors have booths setup displaying their wares. In order to get a free drink you just go up to the vendor and ask for a drink ticket. It's considered polite to show interest in the vendor's products. This is not a big deal but they are paying for your food and drinks.

Saturday is full of training sessions. The sessions start on time and tend to be intensely focused on practical matters. At the end of the sessions time is allowed for questions. It doesn't hurt to take notes on things you might want ask about at the end of the session. Questions are answered by the speaker, by other filers or both.

There are drawings for door prizes throughout the day.

Lunch is a buffet and it is a good buffet. There are a bunch of tables set up. After you go through the line you look around and find a table and sit down. You may sit wherever you wish and this is a good way to get to meet speakers or other filers. In many cases this is also a kind of informal training as a lot of things discussed at the table are work related.

The four o'clock session is a free beer session sponsored by Carbide Processors. Free beer, wine and sodas during the last speech.

The greatest benefit comes from contacts. Meet some people. **Get cards from Vendors.** Then you have someone to call when you have a problem. They may not know but they can refer you on. Two or three calls or emails and you can have a straight answer and a real solution.



Carbide Processors, Inc.  
3847 S. Union Ave.  
Tacoma, WA 98409

PRESORT STD  
US POSTAGE  
PAID  
Tacoma, WA  
Permit No. 356

ADDRESS SERVICE REQUESTED

## Inside

### **1. Make Money Selling Scrap**

How to ship 30# for \$11 and make about \$225.00

### **2. Western Sawfilers Meeting**

September 16 & 17 in Portland, Or  
All Bandsaws - all Day

### **3. Solving Filing Problems**

One of the huge advantages of attending the Sawfiler meeting is to meet other filers. Show up at the Peerless Booth and tell them you want to be introduced to other filers. Next time you have a problem you may be able to solve it with a couple phone calls to other filers. (Plus free food, beer and door prizes.)

## **We Have Carbide**

We saw the problem coming and greatly increased our inventory.

We have been multi-sourcing carbide from around the world now and we are pretty good at it.

If you are having problems with your current supplier we can probably help.

## **Braze Alloy in Small Quantities at Good Prices**

800 346-8274

## **We Also Sell Flux**

White, Black and Purified Black

## **Chinese Carbide**

We are the experts on pretinning Chinese Carbide. We are on the west coast so there is no additional shipping and very little extra delay.

### **Carbide Grades to Solve Problems, Cut Costs and Improve Productivity**

You really should try our Super C and Cermet 2 grades of saw tips.

Super C replaces all grades from about a C 1 ½ to a C 3 1/2. It gives much longer life and is much harder to break than any of these grades.

Our Cermet 2 replaces C-4 and gives much, much longer life. The Cermet 2 is much better than the original cermet grades. Cermet 2 grades braze and grind just like C-4 carbide but stays sharp a lot longer.