



INTERNATIONAL SAW AND KNIFE ASSOCIATION

# Cutting Times

Summer 2013

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Please Join Us....  
Friday July 26, 2013  
MARGARITAVILLE  
Annual Meeting 5:30pm  
Reception Following

3555 Las Vegas Blvd. Inside the Flamingo Hotel and Casino  
ISKA Booth # 8936, Las Vegas Convention Center



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# Blast From The Past

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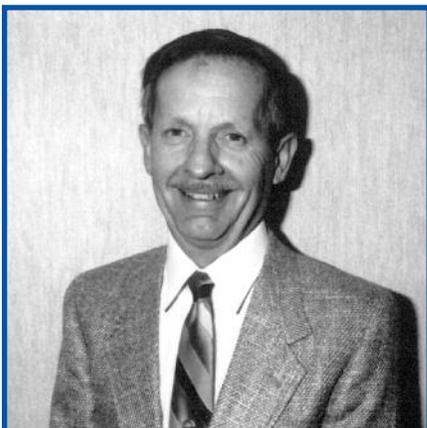
ISKA will be celebrating their 50th anniversary of education and fellowship in 2015. The organization held its first annual meeting on 10-1-1965 with a roster of 14. Over the years, dedicated members have volunteered countless hours and resources to strengthen the group and keep it relevant to our marketplace. ISKA will recognize some of the “major players” in this issue and further issues as a tribute to our 50 years. VIEWER WARNING! We also received some photos from past president John Capozzi, so, we thought we’d have a little fun. Past presidents and board members: Photos 1989



**John Capozzi** (1980-1981) Acme Saw Company (retired) John is living in Conshohocken, Pa. and would enjoy hearing from you. Please call 610-825-3241 especially if you are a good-looking single lady or know any.



**Ezio (Ben) Binelli** (1988-1989) Michigan Saw and Tool (deceased) Although Ben was a mainstay for years on the Board and Master Hammersmith at the seminars; a lot of us remember Ben’s beautiful voice. No ISKA trip was complete without Ben’s singing!



**Ted Andresen** (1996-1997) Apex Saw Works (retired) Ted and wife Elaine live in Reno, NV and winter in Palm Springs. Ted and Elaine organized one of ISKA’s great European trips. Now, both are well and enjoy watching son and grandson grow their business.  
[elaineted@att.net](mailto:elaineted@att.net)



**Fred Oleson** (1986-1987) E.G.Oleson & Son (retired) Son of founding member Sumner Oleson (1967), and Master Hammersmith; Fred organized educational seminars. Now he is enjoying retirement in Maine with wife, MaryAnna and his two sons who live nearby.  
[fmoleson@yahoo.com](mailto:fmoleson@yahoo.com)



**Jerry Brillhart** (1990-1991) Saw Systems, Inc.  
(semi-retired) Jerry keeps busy working in sales three days a week and golfing whenever he can. He wouldn't miss the annual meetings when held in Las Vegas.  
[jbrillhart@sawsystemsinc.com](mailto:jbrillhart@sawsystemsinc.com)



**Jim Battenberg** (1994-1995) Eide Saw & Tool Service (retired) After 62 years of marriage, Jim lost his wonderful wife Doris; so, he goes to Eide Saw every day. He makes blade racks, tables, and book shelves. He riles up all the employees and then goes home!  
[janeb@eidesaw.com](mailto:janeb@eidesaw.com)

**Anyone who would like to add a photo or funny ISKA anecdote for future issues, please email me.**  
[nbrillhart@sawsystemsinc.com](mailto:nbrillhart@sawsystemsinc.com)  
*Stay Sharp!!*

## **ISKA Safety Tips: *Avoid Distracted Driving***

If you have route drivers or salespeople, you may want to have a safety discussion on the topic of distracted driving.

**Fact: Of the more than 65,000 people killed in car crashes over the past two years....1 in 10 were in crashes at least one of the drivers was distracted.**

While phones and fast food cause their share of driving fatalities and thought to be #1, here is the list of the top ten.

- 1) Generally distracted or "lost in thought" (daydreaming): 62%
- 2) Cell phone use (talking, listening, dialing, texting): 12%
- 3) Paying attention to an outside person, object or event: 7%
- 4) Interacting with other occupants: 5%
- 5) Using or reaching for a device in the vehicle such as a portable GPS system or headphones: 2%
- 6) Eating or drinking: 2%
- 7) Adjust audio or climate controls: 2%
- 8) Operating other in-vehicle device, such as adjusting the rear view mirrors, seats, or using OEM navigation system: 2%
- 9) Moving object in the vehicle, as an insect or unrestrained pet: 1%
- 10) Smoking-related (smoking, lighting up, putting ashes in the ashtray): 1%

***REMEMBER...STAY SHARP AND BE CAREFUL OUT THERE!!***

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# Band Saw Blade Efficiency



In the fast paced world of technology today, we are all faced with new and more complicated devices in our tools, machinery and equipment that are designed to make things faster, easier, more productive and less expensive as an end result.

As the oldest continuous manufacturer of saw blades in the United States, it has become more apparent every day in spite of the latest technology in equipment and machinery, saw blades included. It seems to be everyone's goal to do things faster, cheaper and with less effort than ever before. Today's saw blades are made from the best steel available and are manufactured on the latest and best equipment attainable.

All blade manufacturers produce a product that will perform satisfactorily given the opportunity. Modern cutting tools including saw blades are generally of consistent quality more so than the vast types of the material that is being cut such as all varieties of wood, laminates, plastics, etc. There are far more inconsistencies in the material being cut, machine conditions, improper applications and human input than in the cutting tool that are actually expected to neutralize and abolish these many inconsistencies. A band saw blade is a somewhat unstable tool due to its very nature. It has to be relatively thin and narrow in order for it to flex, bend or twist as it does on any common saw machine. This coupled with blade tension (to make it cut square and track properly on the saw wheels) and cutting forces are generated when the saw teeth bite into the work piece removing material from the kerf creating tremendous force that tried to rip the blade in two or break out the saw teeth. These forces are severe enough when everything is in order including speed or velocity of the band, the feed pressure, the force of which the blade is fed into the work piece or conversely the work piece is fed through or into the blade. If improper speeds or feeds are used while cutting, problems are multiplied several times resulting in much reduced blade life due to excessive heat and abrasion, deformation of the back of the blade,

crooked or washboard type cuts. This can be very overwhelming and confusing to some, but if you take the time to walk through it systematically you will find that most cases you can find the situations that are causing your problems.

So before you start making changes to the saw set up or ordering different style blades let's first walk-through the things that can affect the performance of the saw blade.

First let's check the belts and pulleys on the drive line of the saw as well as the wheels condition and bearings in the wheels. Check for cracks or chunks missing from the drive belt and that the belts are riding properly under the right tension in the pulleys. The wheels that your band travels on should be free and clear of any debris on the surface creating a smooth surface for your band saw blade to run. If the tire on the wheel is damaged it may cause the band to track improperly and create fatigue to the band saw blade causing it to break. A worn or damaged wheel can also cause tracking issues on your band saw blade.

At this point you should also check the wheel alignment of your machine because if the wheels are not in alignment the band saw blade will not track properly and may cause the blade to pull away from the fence during cutting. Once you check the alignment of your wheels you should install the saw blade putting about a third to a half the amount of normal tension on the saw blade then spin the wheel by hand allowing the blade to track into place. The band should be running at the center point of the wheel. Do not try to do this with full tension on the saw blade because it will imbed itself into the wheel not allowing the track into place properly. Once you get the band tracked into place properly it is time to move on to the next step (tracking location may vary from one saw manufacturer to another, if you are not sure of the proper tracking position contact your saw manufacturer).

Now we need to work on our guides set up. You have guides above the table and below the table and whatever you do above the table you must do below the table and in some cases the guides that are under the table are not as accessible as the guides on top of the table but in any case they must be adjusted properly. The backup bearing or thrust bearing should be adjusted 1/64th of an inch from the back of the band saw blade when it is tracking properly and under normal tension. The side guides should have no more the gap than the thickness of a piece of paper. This will support the body of the saw blade which will allow you to make straight accurate cuts (please note the side guides need to bleed below the gullets of the teeth on the saw blade, if the guides are riding and striking the teeth you will damage your guides and you will also damage the teeth of the saw blade causing the blade to cut crooked or break or both).

When we have our blade tracking properly and the guides adjusted properly, we need to make sure that the table is square to the band saw blade or you will never make a square cut. By using a machinist square you can check to make sure the table is square to the blade.

Once you've gone through these few steps you should be able to go to work producing accurate, precision cuts. Provided you selected the proper saw blade for the application, make sure you are engaging the right number teeth to get efficient cutting action from your saw blade. It is good practice to check with the manufacturer of a good quality saw blade like Diamond Saw Works, the manufacturer of the Sterling saw blade line to make sure you have the right blade for the job.

Band saw blades are manufactured in many different styles suited to specific materials and tasks. Blades vary in tooth pattern and teeth-per-inch (TPI) as well as in type of steel and blade width. Accurate re-sawing requires a different blade than crosscutting wood or miter cutting stock. Blade guides and blade tension must be properly adjusted for each type of blade.

The regular tooth style with raker set is the usual choice for general purpose wood sawing. Raker patterns set or bend a tooth slightly to the left, followed by a straight

raker tooth and a tooth set right. Skip-tooth patterns with a blank space between teeth are less prone to clog. Hook tooth patterns use a chipping action rather than a scraping cut and quickly clear waste material. Modified hook tooth blades are preferred for re-sawing wood.

Some things to remember when band sawing. Keep machine clean and free of all debris and well maintained. Know what you are cutting before you try to cut it. There are vast differences in how you cut materials and different sizes of materials. This is especially true cutting wood that is extremely hard like Osage Orange, White Oak and Hickory compared to Aspen or Cottonwood which is extremely soft. Select the optimal tooth pitch for the cutting application. There are no true all-purpose tooth pitch or saw blade. Common sense and experience will help you with your choices. If you are not sure contact the blade manufacturer. Always have no less than 3 to 4 teeth in contact with the work piece.

Do not allow the teeth to run between the guides. Adjust the guides to clear the teeth and the set. Adjust your speed and feed rates for the different types of material and the different sizes of materials. If all else fails contact the blade manufacturer, Diamond Saw Works the manufacturer of the Sterling Saw Blade, for your solutions to all your saw blade needs.

*For Additional information please contact:*

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**Chaffee, NY 14030**

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**Fax: 716-496-6057**  
**rellis@diamondsaw.com**  
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# The Prez Sez...



Success in business is measurable by the “bottom line”; but, what about your personal success in your company as an employee or an employer. Here is where personal responsibility is necessary. Take responsibility! Improvements were never made by making excuses. The “who” and “why” of a situation is not as important as your responsibility in the equation...

Matt Schneider of our company gave me a list of quick and easy (you may want to post these) 8 steps to employee success:

- 1) Have a great attitude.
- 2) Be on time.
- 3) Be prepared
- 4) Full 8 hours
- 5) Work smart. (efficient in your area or territory)
- 6) Keep a GREAT ATTITUDE
- 7) Know why you are here and what you are doing.
- 8) Take control.

Ask yourself about your contribution to a problem. “They” are not responsible for what happens to you. You are responsible. Only you have the power for success! But, as said by Arthur McAuliffe, “If at first you don’t succeed, skydiving is not for you”.

See you in Vegas!

Cheryl Rinicella

