



INTERNATIONAL SAW AND KNIFE ASSOCIATION

Cutting Times

Winter 2009 Volume XXXVIII Number XXX

Winter Meeting



February 26, 2010
Crown Plaza Hotel
River Walk
San Antonio, TX

Crown Plaza Hotel
River walk 111 Pecan Street East
San Antonio, TX 78205
Room Rate \$119.00/night
Reservation cutoff date:
January 15, 2010
Phone: (210)-354-2800
Fax: (210) 354-2700

San Antonio Attractions:

<i>Alamo</i>	<i>River Walk</i>
•	•
<i>San Antonio Zoo</i>	<i>Missions Historical Park</i>
•	•
<i>San Fernando Cathedral</i>	<i>McNay Art Museum</i>
•	•
<i>Sea World</i>	<i>Japanese Tea Gardens</i>

Up Coming Events:

Winter Meeting
February 26, 2010
Crown Plaza Hotel – River Walk
San Antonio, TX

Carolina Specialty Tools
April 29th – May 1st 2010

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TECH TALK - Preventive Maintenance the FITCAL Way

By Paul Ravinski

The importance of preventive maintenance cannot be overemphasized. The entire Grinding room depends upon each machine running when it is needed and upon its operating efficiency. It therefore is vitally important that machine operators and repairmen maintain their machines properly. To achieve this, you first have to understand the true meaning of preventative maintenance.

Preventive Maintenance.

Preventive maintenance is a systematic series of operations performed at regular intervals on equipment to eliminate major break-downs and unwanted interruptions in service, and to keep the equipment operating at top efficiency. To understand what is meant by preventive maintenance, it is necessary to distinguish between preventive maintenance, troubleshooting, and repair.

The prime function of preventive maintenance is to prevent breakdowns and, therefore, the need for repair. On the other hand, the prime function of troubleshooting and repair is to locate and correct existing defects.

Important Techniques.

Even though it is rugged equipment, many of the parts used in grinding machinery require routine preventive maintenance and careful handling. Hit-or-miss maintenance techniques don't work. Specific instructions are needed. The easiest way to assure preventative maintenance is happening in your grinding shop is to attach a checklist right to the machine. Make it visible (see above photo of a checklist attached to an AL805 grinding machine).

FITCAL is a tried and true acronym that is easy to remember. It lays out the six basic maintenance operations as follows:

F-Feel
I-Inspect
T-Tighten
C-Clean
A-Adjust
L-Lubricate

The first two operations establish the need for the other four. For example, the carbide encountered while grinding saws and tools gets into your machine no matter how much care is taken to prevent it, causing corrosion of exposed surfaces and parts. Feeling and Inspect-



A FITCAL checklist, shown here in plastic sleeve on this AL805, is a tried and true, easy way to remember six basic maintenance operations every grinding shop should do to prevent breakdowns and interruptions in service.

ing your machine daily will tell you if it is necessary to tighten, clean, and adjust, or lubricate your machinery before it becomes undependable and subject to breakdown when it is most needed.

FEEL Operation.

The feel operation is used most often to check rotating machinery, such as blower motors, drive motors, bearings, and bushings, and to determine whether electrical circuit components are overheated. Feeling indicates the need for lubrication Tech Tidbit and the existence of circuit defects requiring correction. The Feel is applicable to preventive maintenance of grinding machinery so feel your motors and spindles for excessive heat or vibration.

INSPECT Operation.

Inspection is the most important operation in the preventive maintenance program. A careless observer will overlook the evidences of minor trouble. Although these defects may not interfere with the performance of the equipment, valuable time and effort can be saved if they are corrected before they lead to major break-downs. Make every effort to become thoroughly familiar with the indications of a normal functioning machine in order to be able to recognize the signs of a defective machine.

Inspection consists of carefully observing all parts of the equipment, noticing the color,

placement, and state of cleanliness. Inspect for the following conditions:

(1) Color: Overheating can be indicated by discoloration, blistering, or bulging of the parts or surface of the machine. Leakage of hydraulic oil and oxidation of metal contact surfaces are also identifiable by changes in color.

(2) Placement: Check that all leads and cabling are in their original positions, connected securely and not frayed.

(3) Cleanliness: This is the #1 problem we see in American Grinding shops. Accumulation of carbide or steel, especially between electrical parts, connections, and joints will eventually freeze moving parts and cause rust and corrosion to form.

TIGHTEN Operation.

Check tightness of belts, bolts, fittings, wire connectors and plugs. Caution: Screws, bolts, and nuts should be tightened carefully. Fittings and belts tightened beyond the pressure for which they are designed will be damaged and broken.

CLEAN Operation.

Clean your machines faithfully. This is one of the most important rules. A dirty machine will be prone to early failures. If you have a full cabin machine and aren't using oil coolant, consider it. Machines running oil coolant are much easier to keep clean.

ADJUST Operation.

Adjust drive belts, grinding wheel belts, feed fingers.

LUBRICATE Operation.

Lubrication refers to the application of grease or oil to the bearings and shafts of motors or other rotating parts, sliding surfaces, and wherever minimum wear due to friction is desirable. Check levels of hydraulic and auto lube reservoirs.

*Courtesy of Colonial Saw.
To receive Colonial Saw's free
e-newsletter, please contact:
Deborah Katz at
dkatz@csaw.com*

Walk Down Memory Lane



Walk Down Memory Lane



New Members

Expert Die Inc.

has been in business since 1993. We are located in Dalton, Georgia. The Carpet Capital of the world. Originally we manufactured steel rule cutting dies for the carpet samples. Over the years we have evolved to fit the needs of our customers. Currently we sharpen and sell many different blades including paper knives, circular knives, shear blades, saw blades, router bits, compression bits, cutters, and specialty tools, just to name a few. In 2007 we began manufacturing special tooling. In spring 2008 we were chosen as a Freud Authorized Sharpening Service Center. We serve areas of North Carolina, Tennessee, Alabama, and North Georgia including the Atlanta area. For more than 15 years our philosophy has been exceptional customer service. We are a family owned business where customer satisfaction is first. Expert Die Inc. is owned and operated by Eric and Dawn Barr. We are excited about becoming a member of the ISKA organization. If you are interested in learning more about Expert Die Inc. see our website at www.expertdie.com.

Julia Utensili S.P.A.

is now the world wide leader in metal cutting with circular tools and it is placed as ideal partner in order to resolve all the requirements of the customers. Thanks to the experiences matured in many years of activity from the highly qualified staff, in our modern equipped plant we execute all the working process, from the heating treatment of the discs till the marking of the finished product, in order to obtain a quality product, certified by ISO 9001 norm.

Julia Utensili has a complete range of HSS circular saw blades on catalogue, with 20 till 620 mm diameter and 0,15 till 6,0 mm thickness, as well a series of saw blades for specific applications, like screw-slotting, jewellery and orbital tube cutting. Beyond the carbide tipped saw blades for non ferrous materials, dry-cutting and steel-cutting, we manufacture also circular knives for various industrial applications. Over 85% of the orders are despatched from stock, coming encounter to the demands for a more and more demanding market.

Pretinned Carbide Company, Inc.

has been providing the finest service to saw service centers and manufacturers since 1988! Our staff is continually learning the latest techniques and best-suited products for maintaining safety and efficiency in the brazer's work environment. Pretinning is the process of affixing silver solder to the body of a part in preparation of it being brazed to another part.

With the production of over 12 million parts per year, we have proven ourselves to be the leader in:

1. Consistency of order service
2. Physical piece count system service packaging
3. On time delivery
4. Quality pretinned parts

Users of carbide parts have found that by using carbide that has been properly cleaned and pretinned is faster, easier, more cost efficient, and of higher quality. It also ensures a more consistent application of silver solder thereby reducing waste.

We sell Silver Wire to saw shop in sizes of 1/16 (.063) or 1/32 (.032), all silver solder is cadium free. We sell Trimet Shim (silver-copper-silver strip) in various sizes. We sell various fluxes. So if the need arises we want our customers to feel like Pretinned Carbide is a company that can supply them products used in their braze applications.

Shelba Bissell / owner

Used Equipment Connection

Smithing Stands priced from \$6,495.00 to \$7,495.00
Please call Karl Schmidt 802-334-6365

1984 Akemat U ATB cabide saw grinder with steel relieving
Option \$14,500
Please call: 412-278-0655 x235

2008 Vollmer demo CX 100 4-axis CNC top and face grinder
Price: \$48,500
Please call: 412-278-0655 x235

2002 Vollmer CHD 251R2 with ND 230 robot
Completely rebuilt w/ 6 month warranty
Price \$125,000
Please call: 412-278-0655 x 235

2008 demo Vollmer CHC eco top & face grinder
Price: \$29,500
Please call: 412-278-0655 x 235

To List your used equipment Please
Fax Cheryl Rinicella @ 330-963-2985 or email
crinicella@sawsystemsinc.com

The Prez Sez...



Ouch! What a year. I don't know about you but in November of last year our sales dropped by over 30% and are still at that level. I was really surprised at how fast our sales dropped and even more frustrated by how long it took to shed expenses.

The good news is, we are still here and sales show signs of improving. We are seeing more housing starts now but it is way too early to think this is over. I am anticipating a slow winter and hope to see business pick up in the spring.

Managing a business is tough enough in good times and is even more challenging during a slumping economy. Employees can go home and forget about work but owners and managers are burdened with planning and thinking about "the shop" night and day. At work we have to walk through the shop looking confident when we're worried about survival, motivate and inspire when we're not motivated or inspired, ask good people to work harder for less and still carry the burden of making payroll, payables, manage work flow and more.

Recently I read an article in *Cutting Tool Engineering* written by Keith Jennings of Crow Corp. in Texas. In it he said: "As you walk through your shop and manage activities, do so with strength and confidence. Employees desire it. Will it be easy? Of course not! It's one of the most challenging situations you'll ever experience. Staying the course, being decisive and trusting your instincts are difficult. Pondering these matters while out with the family has been a common occurrence for me this year and I hate it. It goes with the territory, but even so, it's still a tremendous burden when you can't relax because of persistent concerns about your livelihood."

"It's also essential that employees have confidence in your skills and the company's direction. You're expected to display calm, decisiveness and honesty, among many other qualities. You're expected to set a rock-steady example of management prowess, even when inside you may be scared to death."

During difficult times I always fall back on something my Dad used to say "Persistence Wins All Battles". I think of that often these days and it encourages me to keep going. So stick to the fight when you're hardest hit- it's when things seem worst that you must **NOT QUIT!**

Good luck to each of you. Remember - difficult times are a time of great opportunity.

Mike

***"Success is never final; failure is never fatal;
it is courage that counts."***

-Winston Churchill