



INTERNATIONAL SAW AND KNIFE ASSOCIATION

Cutting Times

Summer 2018

ASSOCIATION NEWS – MEMBERS INVITATION

Board Meeting Announcement

ISKA will hold its summer board meeting on Friday, Aug. 24 from 12:00pm-3:00pm inside the Atlanta Georgia World Congress Center during the IWF, in Room C210. We will be accepting nominations for the Chair positions, and reviewing other association business and planning for future events. All members are welcome to attend the meeting. Ideas always welcome. We want to hear from members.

You are invited! Reception Invitation

During the IWF event in Atlanta, ISKA will have a booth where Board Members and member volunteers will greet folks and offer more information about the benefits

of joining ISKA. If you'd like to help out, contact Dan Zickel at dan@quinnsaw.com In any case, please plan on stopping by our booth Booth BC 25 (walkway between Halls B and C) to say hello! We'll have a resting stop to chat with other members and network.

Thanks to our sponsors*, Sharp Tool Co., Colonial Saw, Grasche, and Everlast Saw, more networking opportunities will happen at the **ISKA Reception** which will be held at **STATS Brewpub**, 300 Marietta St. NW, Atlanta from 7 – 10 pm on Friday, Aug. 24th. Stop by the ISKA Booth to get the invitation or call a Board Member listed in your Roster Book (or check ISKA.org or the Facebook page!)



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The Prez Sez...

How is business?

I see personally every company I deal with is very busy. I need a new machine and the lead time is eleven months. How is that for busy? Lead times are long both in the USA and other countries. So when the USA is booming so is everyone else. I see empty business complexes that have been empty for years starting to come alive. I have spoken to many others in the woodworking, recycling, food, and textile industries and everyone is excited about how business is going.

The upcoming IWF in Atlanta is going to be busy and exciting. Don't forget the ISKA party is Friday 8-24-18 at 7:00 pm to 10:00 pm. This is a great time to talk shop with other sharpeners and suppliers.

My conclusion is to get ready for the next few years and enjoy it.

“A satisfied customer is the best business strategy of all.” —*Michael LeBoent*

Thanks,

Eric Barr

Expert Die, Inc.

ISKA Board President



IWF GUIDE

If you go to the International Woodworkers Fair, be sure to visit our RECEPTION SPONSORS and support our associate members with a friendly hello and check out all the new equipment trends and innovations. Here's a quick guide listing many of our associate members.



ISKA Booth: BC 25

Amana Tool 4752

Bestar

Ceratizit / HMT 4428

CMT USA 4652

***Colonial Saw 6569**

Dino Saw, 5070

Equipment Ltd. 7228

***Everlast Saw @ISKA Booth**

Freud America 6947

***Grasche 4428**

H3D Tool 4573

Hickory Saw & Tool 7801

Moon's Saw Shop Supplies 7800

Peerless Saw 6524

Popular Machinery and Tools 5437

Riverside Tool / Intooligence 4734

Royce / Ayr Cutting Tools 7953

***Sharp Tool Co. 6020**

Sharpeners Report / @ ISKA booth

Skarpaz Tooling Systems 6447

Southeast Tool 4735

Super Thin Saws 5552

The Sharp Tool Co. 6020

Vollmer of America 6412

Vortex Tool Co. 4434

Williams & White Equipment 4467

There are certainly more suppliers to see there. We appreciate our Associate members of ISKA who offer supplies to sharpening shops across the USA. Bring your smile! Board Chair Judy Brenner, owner of Sharpeners Report and the Cutting Times Editor, will capture as many booth photos and reception photos that are printable in our next newsletter! Show off your booth and handshake with visiting prospects. You can plan your visit by referring to this web site for all exhibitor locations: iwfatlanta.com

Special Tooling and Groovers

By Paul Hardenberger, Everlast Saw

We receive many calls with questions about the economics of using a “special” saw vs. some combination of “standard” saws. Often these



12" x 24 Tooth x 3/8" Kerf +15 Hook 2.5" Bore
Keyway: 2 ea .375" W x .451" D

questions center on making a groove rather than ripping or cross-cutting. A common example is making a 3/16" or 1/4" groove in a drawer side for a drawer bottom. While I cannot provide you with a firm Yes or No, we often discuss the pros and cons of buying a “special”.

Typical Groover Arrangement Using Standard Items

Many standard 10" and 12" saws have a .125" (1/8") kerf or perhaps something smaller. If the user needs to make a groove, they sometimes run several saws together to obtain the desired groove width. Another option is to utilize a dado set with two outside saws and chippers (typically with shims) to provide the desired width. Both alternatives are effective, but they do have drawbacks.

Grooving With Multiple Saws

This is typically not a great option as finding saws whose teeth “interlock” is not always easy to do. If the teeth do not interlock, saw chips can build-up between the



300MM x 24 Tooth STR 80mm +10 .375
Plate .500 Kerf Pinholes 2/13/100, 8/7/95

plates and cause out-of-balance issues and may even cause the groove width to be wider than required. Also, sharpening multiple saws is more expensive than sharpening a single saw or groover.

Dado Set

This is an effective and widely-used alternative, but the biggest complaint we hear is the unit being assembled incorrectly. This is due to shims or chippers being left out of the installation. Occasionally a chipper will be installed

backwards which increases set-up time to correct this condition. Finding a dado set with the correct number of teeth can be an issue. For example, an end-user might be running an 8" x 24 tooth dado set when a better configuration (for cutting speed and cut quality) might be 6" diameter with 6 teeth. Sharpening a dado set is typically more expensive than a single saw or groover.

Groover Benefits

Application Specific

The goal with most grooving applications is a fast, clean, flat bottom groove. In this case, a simple Straight Top Grind (STG) (AKA Flat Top Grind) works very well. Often the number of teeth can be reduced to increase cutting speed and productivity without negative impact on groove quality. The appropriate top grind and hook angle can also be selected. So, having the “right tool for the job” is very possible with a dedicated groover.

Simplicity for the User

Since there is only one cutting tool to install, there is no chance of incorrect installation. We often laser engrave the Work Center Number or Department Name on the groover so it is returned to the correct machine and application at the end-user's facility.

Durability and Service Life

Groovers use heavier plate and wider carbide both of which are more durable than the same elements on a standard saw. Thus the groover could be re-tipped in the future after multiple sharpenings.

Smoother Cutting / Cutting Speed

When a dado set and chippers are used to make a groove, the outside saws may have 24 to 40 teeth while the chippers most likely have 2-tooth or 4-tooth designs. With this “mismatch” in cutting tools, the cutting speed will be limited by the chippers. Try to cut too fast and



10" x 60 Tooth Alternate with Raker
4+1 1/4" Kerf 1" Bore .188" +10 Hook

Special Tooling and Groovers, continued from page 3

the operator will experience vibration issues (or worse). A groover with the correct kerf will provide a smooth, precise, clean and quality cut at a faster speed.

Price

Everyone has a valid concern about cost. To minimize cost, we often modify a standard groover's kerf width and avoid the cost of a 100% "special" groover. If a specific diameter and/or tooth configuration is required then a special design will be created.

Sharpening Cost

As discussed above, sharpening a single groover is less expensive than other multiple saw alternatives. Further, the groover can most likely be re-tipped after multiple sharpenings which will further extend its service life.

Cost-Per-Groove (Total Cost of Ownership - TCO)

I finish with this item as in my opinion this is the most important topic for discussion. Everlast makes industrial-quality saws for industrial users. Most of our customers are NOT looking for the least expensive (cheapest) saw or tool, but rather are looking to REDUCE their TOTAL

COST. The Total Cost of Ownership includes the initial investment and also includes all costs associated with set-up, operation and maintenance (sharpening).

Take the time to review TCO components with your customer. Ask them what they like and don't like about their current configuration. Discuss their cutting volume along with tooling options and alternatives. Reaching common ground on an important subject like TCO will help you understand the end-user's goals while building mutual trust and respect which is always good for business.

Thanks for allowing me to share my thoughts. We welcome the opportunity to assist you and your customer in this process and provide a high-quality, industrial cutting tool. Please call Everlast Saw at 800-387-5278.



10" x 60 Tooth Alternate with Raker
4+1 1/4" Kerf 1" Bore .188" +10 Hook

Member Spotlight: AS&T Inc.

Founded in 1976, AS&T Inc. continues to be a family run business based in Campbellsport, WI. President Jody Jaeger has built the company to focus on manufacturing, sales, and service of industrial tooling. Beginning in the back room of his family's home, Jerome Jaeger began his sharpening business concentrated on servicing cabinet makers throughout southeastern Wisconsin. Through the similar determination of Jerome's wife and sons, the company flourished.

Today the business has grown to service ferrous, non-ferrous, plastics, composite, and secondary woodworking industries nationwide. Their delivery service has grown to supply sharpening for the southern upper-peninsula of Michigan, northern Illinois, and the eastern border of Minnesota, as well as most areas within Wisconsin.

AS&T Inc. recently acquired Toolmasters LLC's "small tooling division" in January of 2016. Combining both businesses has helped the company continue their

venture into manufacturing of solid carbide endmills, custom carbide-tipped sawblades, and solid carbide and HSS router bits. Using industry-leading equipment, including ANCA, Vollmer, and Akemet, the company truly focuses on quality. Jody Jaeger says: "It is our belief that 'Quality isn't expensive, it's priceless!'"

Welcome them to ISKA when you get a chance. Contact:

AS&T INC.

**N110 County Highway W
Campbellsport WI, 53010**

Phone: (262) 626-4410

Fax: (262) 626-4217

Email: sales@asttooling.com

Colonial Saw Offers a New Cold Saw Equipment



Colonial Saw will have a new CNC cold metal saw grinding/resharpening machine debuting at the IWF in Atlanta, and the Chicago IMTS shows. This Fully automatic manufacturing or regrinding of HSS cold saw blades

including chamfering in only 1-single pass.

The PNK-AC CNC is an ideal machine for the complete machining of metal circular saws. It guarantees optimum grinding quality with its state-of-the-art technology.

All the data related to the circular saw is entered from the control panel. Fast and precise set-up and adjustment of all axis happens using the electronic handwheel.

Also see the ABM Robotic loader, an 8-axis machine with up to 5 stations. Web: csaw.com/grinding

PNK-AC CNC at a glance:

- 4-Axes servo motor controlled
- PC controlled
- Grinding all common tooth types
- Automatic chamfering
- Blade thickness input from the control panel
- Automatic calculation of the tooth pitch
- Absolute tooth pitch accuracy
- Remote programming and troubleshooting
- Central lubrication system
- Variable grinding and wheel rotation speed
- Manufacturing and resharpening using CBN, or switch to vitrified wheels for tooth removal
- High pressure coolant system for use with oil or water-based coolants
- Totally enclosed cabin for operator safety

Big Show Events

Aug. 22-25 The International Woodworking Fair 2018 will be one of the top woodworking trade shows in the world for the furniture manufacturing, architectural woodwork, custom and general woodworking industries. IWF is a biannual event and takes place every two years at the Georgia World Congress Center located in Atlanta, GA.

The IWF CNC Symposium will be held August 21, 2018 in the Georgia World Congress Center in downtown Atlanta, the day before IWF exhibits open on the show floor. At 1:50 PM – 2:40 PM: hear Greg Neer, Freud – talk about CNC tooling from start to finish. Cabinet makers will hear many other speakers and you can see the line up on the IWF website: <http://iwfatlanta.com/Education/CNC>

Sept. 10-15 McCormick Place, Chicago: DID YOU KNOW that For 90 years, IMTS has been the premier manufacturing technology show? The last one hosted 2,407 exhibitors, 115,612 registrants within its 1.37 million sq. ft. of floor space. IMTS is held every even year in Chicago and attracts buyers and sellers from 117 countries.



If you go to IWF18, stop by our ISKA Booth to relax and network.



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*Do you have an ISKA Tech Tip
or news to share?*

*Contact the Editor, Judy Brenner
Tel 952-406-8870
Email: Creativelakes@outlook.com*

ROSTER UPDATE CORNER - ISKA MEMBER ADDITIONS:

We are mailing the new updated 2018-2019 Roster books this quarter. Here are the highlights of changes since our last newsletter sent in March 2018. Check you books for more updates! Printing a book is as up-to-date as the latest information on record. Keep in touch so we can include any of your updates in our next newsletter and the annual Roster book printing.

NEW MEMBER

AS&T Inc.

Jody Jaeger, President

N110 County Highway W
Campbellsport WI 53010
Tel: 262.626.4410 Fax: 262.626.4217
Email: sales@asttooling.com

UPDATES

Bestar new contact: Alan Zwickel

Com Surge new address: 13100 Kirkham Ct #203
Poway CA 92064

Concentric Saw new address & Email:
8815 Gauge Drive, College Station, TX 77845
concentricsaw@gmail.com

Intooligence new contact: Brian Deis

Phillips Saw and Tool new email: jordan@psaws.com

Riverside Tool new email: jmigedt@riversidetool.com

The Blade Mfg new address: 915 Distribution Drive
Columbus, OH 43228

Tim Rief & Associates / Sharp Quip new address:
680 Mission St #29F San Francisco, CA 94105

Tungco new email: rdoner@tungco.com