



# Carbide Processors, Inc.

Northwest Research Institute, Inc.

**Newsletter August, 2014**

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

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

## A New Carbide Program

- \* Advanced Grades
- \* The New Multi-Grades
- \* Standard Grades That Work All The Time
- \* An Economy Line

There are a great number of carbide suppliers, maybe more than ever before. Most of them make pretty good carbide most of the time

We wanted to find somebody that made good carbide all the time.

We have found one supplier who has consistently excellent quality. Each tip is individually inspected so there is no jamming in automatic equipment.

Each batch is braze tested using statistical based sampling so the brazing and bonding is excellent.

We tested a whole bunch of the companies that sell carbide cheap. We think we have found the best.

If we put in an inventory for you, we will be able to deliver acceptable quality when you need it.

The cheap carbide is sometimes good enough that the customer does not know the difference. Occasionally there is tip loss, tip breakage, or short run life.

We are still working this out but we are starting to supply new grades and less expensive tips. Call for more info.

## Redding Filers Meeting – Wow

Once again, the California Western Saw Filers Educational Association had a great meeting. There were about 35 filers and about 16 vendors. This is really a huge turnout considering how few mills there are.

It was also an extremely high quality turnout in that the filers that came were there to work. I got lots of good questions. Udo Jahn of Modern Engineering and Paul Duclos of Peerless Saw were next to me and they stayed busy answering questions.

Jim Myren of Benchmark Knife and Saw ended up giving an informal seminar to about 10 people on his straight edges.

Dan lines of Roseburg Saw & Tool, who also makes straight edges, spend a lot of time talking to people about how to use straight edges as well as taking orders for his industry famous hammers.

I did get to hear Joel Garcia's lecture on developing saws for the Waneshear. Joel brought in actual saws and showed the development through a couple generations. The engineer from Waneshear was good enough to admit that they were not saw people. Then he introduced Joel who got up and explained how a saw filer made the machine cut more accurately and greatly improved the time for saw changes.

All in all the filers seem very pleased with the meeting. The only real topic of discussion in the vendors meeting was how to make it easier to get more filers to attend.

## August ISKA Meeting A party and a half

Bill Zickel of Quinn Saw was convention chair and did the organizing. Bestar and Grasche sponsored the event. (828) 322-3253 800-GRASCHE (800.472.7243) emailsales@grasche.com Klaus Jensen Call Klaus and order a couple tons of plate in Bestar steel. Yes, that is a lot of plate but the party was that good.

There was a huge attendance this year at the ISKA meeting. It was at Der Biergarten again. We had a big room and a really big deck both of which ended up being crowded.

My biggest memory of the party was seeing a happy man with a heaping plate of sausage and taters in one hand and a big stein of beer in the other.

Natalie Brillhart and Cheryl Rinicella deserve a lot of credit. They spent the whole day of the meeting working the show to recruit people for ISKA and for the party. When I think about it, the idea of sending two pretty and attractive women out to invite saw and tool guys to a party with free food and beer is pretty much a perfect marketing strategy.

### **Rudi Sommer, Paul Duclos & Bill and Diana Saily are heroes (heroines)**

These four people do a huge amount of work to put on the filer shows. I just thought I would mention it. For

Rudi and Paul it is work but still they go way above and beyond job requirements. It used to be part of Bill's job and poor Diana just got volunteered.

# Western Saw Filers

## A great program for 2014

Scott Erickson and the board have done their usual excellent job in setting up a program that provides real filer-to-filer information. The goal is to give filers information that they can use to improve their mills performance immediately.

### Keynote Speaker

Bob Banchemo, the new general manager at Columbia Vista, has also agreed to speak. Columbia Vista does an excellent job in getting the maximum dollar out of each log through ultraprecise sawing. Mr. Banchemo is also a devout safety advocate and has some excellent ideas in this area.

The program starts where the cutting starts with the bandsaws. If the first cut is bad then you are in trouble from there on out.

Neil Lean leads off with a discussion on the all-important strains and guide pressures. These issues are critical for bandsaw control to ensure straight, clean cuts and thus maximum recovery from each log.

Next is Scott Emmert talking about variable pitch bandsaws. We are very lucky that Scott was able to find time for us this year. He is extremely busy as an international consultant because he really produces results.

Williams and white machinery from British Columbia is coming down to talk about filing room automation

Dan Lines will talk about hammering which ties in nicely with bandsaw stress and strain.

Rudi Sommer is going to do an industry overview of mill closures

for the last couple of decades. This is partly a nostalgia piece. Mostly it is a reminder that we all have to work to keep our Mills open.

The registration information for the Monarch Hotel at Clackamas is as follows:

MONARCH HOTEL &  
CONFERENCE CENTER TOLL Free:  
1-800-492-8700 (FAX) 503-652-7509

### Why saw shops should attend and exhibit at Saw filer Meetings

More and more mills are having shops do their work. Round saws, carbide and knife work seem to be most common.

### Official Letter from WSFEA

This is our 53rd year and we welcome all saw filers to attend our educational conference and banquet festivities on September 12m and 13<sup>th</sup>!

Once again we will meet at the Monarch Hotel in Clackamas Center.

The Jay Erickson Memorial Golf Tournament starts the weekend off on Friday for all vendors and filers.

Friday's Vendor Appreciation Night kicks off at 6:00 p.m. as Rudi Sommer has once again organized an evening of fun, food, and friendship. Vendors will have booths in the Hospitality Room downstairs and there will be door prizes, casino-style gambling with Texas Hold'em, blackjack tables, roulette wheel, and a crap table for enjoyment for all attending.

Entertainment for registered guests will be from 8:30 —10:30 p.m. A light dinner fare will be available with the festivities so please come and enjoy the Friday fare courtesy of our sponsoring vendors.

The annual Jay Erickson Golf Tournament is in the capable hands of Golf Director Mike Posekany of Munnell & Sherrill. Mike has once again chosen Oregon City Golf Club at Lone Oak located at 20124 Beaver Creek Road in Oregon City for the

Friday the 12th tournament. There are a limited number of slots available so REGISTER EARLY and we'll see you at Lone Oak for golf and door prizes.

Our newest additions to the Western Saw Filers' Hall of Fame for 2014 will be Foy Leatherman and *Walt Bennett*. Please join us for the banquet festivities and induction ceremonies Saturday evening and celebrate the 53<sup>rd</sup> year of our Educational Conference. Bill Sally Secretary/Treasurer W.S.F.E.A.

2014 WSFEA GOLF TOURNAMENT  
Oregon City Golf Club at Lone Oak  
20124 Beaver Creek Road  
Oregon City, OR 503 518-2846  
Friday, September 12th 2014  
GOLF - NO CART : \$55.00  
GOLF - WITH CART : \$65.00

Includes a sack lunch at the turn  
SCHEDULE: Our first starting time is 9:00 am. We have 32 spots available first come, first (paid in) served.

HOW DO I SIGN UP: Make checks payable to: Mike Posekany / WSFEA Golf And Send to:

Mike Posekany

CIO

Munnell & Sherrill INC.

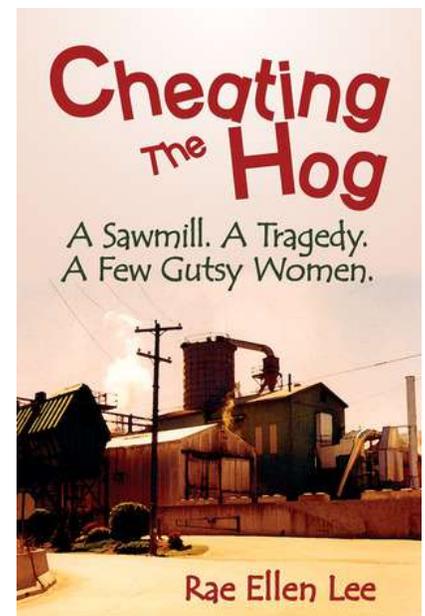
Box 13249

Portland OR 97213

DEADLINE FOR ENTRY: NEED NO LATER THAN FRIDAY, SEPT 5, 2014

CONTACT INFORMATION: Mike Posekany -Office: 503-281-0021 – 503 804-3603-cell (best)

mikeposekany@munnell-sherrill.com



## Scrap

We are currently paying \$8.40 per lb. for both scrap tungsten carbide index able inserts and clean solids without steel or silver brazing attached. Carbide wire and draw dies and carbide with silver brazing are \$8.10 per lb. The Stellite™ Alloy 12 is \$3.50 per lb.

### Scrap prices change frequently. Call 800 346-8274 for current prices

Shipping terms are FOB Tacoma, WA. As discussed, you may ship prepaid with your carrier of choice. We do not recommend UPS. The United States Postal Service offers Flat rate boxes for approximately \$15.00. These boxes hold 50 lbs. and are a very economical way to ship. Here are a few tips for shipping via the USPS.

1. Carbide should not be loose in the flat rate box, please place it in a container, such as a coffee can, cookie tin or wood box.
2. Use newspaper to fill empty areas.
3. Please make sure to tape the entire package with sturdy shipping tape, especially around the corners, sides, and end.
4. Mark each of the boxes as "heavy".
5. Do not drop the boxes into a mail slot, bring it directly to the post office, or have your carrier take it.

Please do not hesitate to contact me if you have any questions or if you require additional information.

Thank you  
Emily George  
Carbide Processors  
800-346-8274  
www.carbideprocessors.com

## Free Coolant Test Kit



A Free kit for testing your Machine Coolant.

Machine coolant can accumulate bacteria and small particles that can be harmful for the operator and the equipment. It is important to test your machine coolant to see if there are bacteria present and check the number and size of small particles.

If there is a problem with bacteria, pH levels, or large particles in the machine coolant, it may make sense to filter your coolant. Filtering your machine coolant can save you money and reduce the time and cost of frequently having to replace machine coolant.

We think this is important but not everyone does. We decided to give away simple test kits. Just call 800 346-8274 or email [sales@carbideprocessors.com](mailto:sales@carbideprocessors.com)

One bacteria / fungus test, five pH strips and one 250 ml cylinder plus shipping no charge.

<http://www.youtube.com/watch?v=sCs74KwiL8U>

## Door Prizes

West, Mike  
WestWM@chwa.com

After the Board of Director's meeting last weekend, I decided to throw out a question or two.

What sorts of door prizes do you like the best? The vendor's try hard to pick out prizes we like but could use some suggestions and input.

In addition, we are still looking for a candidate for an open Director position.

### Some suggested gifts

- \* Starrett 12" machinists' level is always a good one.
- \* Starrett precision combination tri square
- \* Starrett 4' precision straightedge – this is a six-pound tool that I cannot live without – not your typical straightedge
- \* Starrett mag base dial indicator (1")
- \* Starrett inside mike set
- \* Mitutoya digital tachometer
- \* A "spider" from Thin Kerf Technologies
- \* Digital 6" calipers
- \* 6" dial indicator calipers

These are all tools a skilled filer should have in his arsenal.





## Scott Erickson Strait Line Saw Performance

I started Strait Line Saw Performance to help saw mills maximize profit in today's market with current log prices.

To do that we need to run at minimum target sizes with minimum kerf saws at a high rate of speed. None of which is possible without an accurately aligned machine with flat and properly tensioned saws that are designed for your depth of cut and feed speeds.

I have been saw filing for the last 25yrs and in that time I have watched feed speeds double and target sizes drop. Some target sizes in gangs are so low that the difference between maximum kerf and minimum kerf can make a big difference in surfacing at the planner.

Everything is a tradeoff between production recovery and quality and those priorities change with the market but alignment accuracy is required for all.

I do my alignment work with either a Brunson scope or a Hamar laser because these two instruments are the most accurate that I have found for this type of work. I enjoy what I do, I like helping filers, and millwrights understand the

importance of accuracy in everything we do.

I have done work for WKO in Carson and Mt Hood Forest Products in Oregon, Interfor PA, Interfor Beaver, Interfor Molalla, Interfor Gilchrist, Interfor Grand forks Canada, Suwannee lumber company Suwannee Florida and Harrigan lumber company in Monroeville Alabama.

I have found machines off as much as  $\frac{3}{4}$ " in critical areas that had been over looked during routine alignments. I have not found a machine yet that I was not able to improve alignment on with this equipment.

I also show the filers and millwrights how to do their routine alignments more accurately with the equipment they have.

In one of the more extreme cases that required alignment of multiple machine centers, new saw designs, improved saw guides and lubrication system, we were able to drop target sizes .050 and still maintain the mills high feed rate.

I asked a mill manager one time what the dollar value of the work was. His answer was; even though the economy is in the tank we are able to keep these people working. That was good enough for me and I have not asked anyone sense.

Scott Erickson  
Lead Filer  
INTERFOR  
Port Angeles Division  
Phone (360)417-6182  
Scott.Erickson@interfor.com]

<http://www.brunson.us/>

<http://www.hamarlaser.com/>

## How Bosses Can Maintain Friendships at Work

Harvard Business Review

It is not always easy to have friends at work when you are the boss. The critical skill senior leaders need to maintain their leadership and friendships is emotional courage – the willingness to act powerfully in the face of deep emotion. Three tactics can help you navigate this complexity – and make you a more capable leader overall.

1. Have a strong, clear commitment to your business objectives. If you want to achieve something, you must be willing to make hard decisions. Be transparent, upfront, and passionate, even as others, including friends, disagree with you.

2. Develop your friendship skills. Certain skills, like unwavering integrity, empathetic listening, and strong boundaries, can help you manage dual roles of friend and business leader.

3. Be prepared to lose the friendship. Recognize that you ultimately cannot control what happens to the friendship. Some people just might not be able to live with your decisions. Learn to feel the sadness and move on.

## Qualified Saw Filers Wanted

Immediate Saw Filer openings are available with Simpson Lumber Company at Commencement Bay Lumber in Tacoma, WA. Only Qualified Benchmen, Qualified Band Saw Filers, or Qualified Round Saw Filers need apply. Requires High School diploma, GED, or equivalency. Candidates must have a minimum of 2 years of experience with band and round saw filing with Stellite® experience. \$22.50 DOE plus Health & Welfare benefits package.

## Food For Thought

I am not saying let's go kill all the stupid people. I'm just saying let's remove all the warning labels and let the problem work itself out.

I changed my car horn to gunshot sounds. People move out of the way much faster now.

You can tell a lot about a woman's mood just by her hands. If they are holding a gun, she is probably angry.

Gone are the days when girls used to cook like their mothers. Now they drink like their fathers.

You know that tingly little feeling you get when you really like someone... That is common sense leaving your body.

I do not like making plans for the day because then the word "premeditated" gets thrown around in the courtroom.

I did not make it to the gym again today. That makes five years in a row.

I decided to stop calling the bathroom the John. I renamed it Jim. I feel so much better saying I went to the Jim this morning.

To the paranoid people who check behind shower curtains for murderers; If you find one.....what's your plan?



## Businesses for Sale

### Sharpening Business in Idaho

I am selling my sharpening business to pursue another career. The business has been for sale for some time, but I recently reduced the price drastically.

We are a full service sharpening shop and retail store in Coeur d'Alene, ID with two satellite locations for pickups and drop offs in Spokane, WA. We have equipment to sharpen kitchen knives, hair shears and clippers, garden tools, industrial knives, router bits, carbide tipped saws, and more.

The sale includes our customer base and all equipment including an MVM BM-850 knife grinder and a Vollmer CHP-eco CNC carbide saw sharpener.

We are not selling in pieces. The current price is less than the CNC machine would cost by itself.

If you are interested and would like more information, please give me a call between 2:00PM and 5:00PM, Tuesday through Friday.

John Thurston  
The Cutting Edge Sharpening and Tool Sales  
Coeur d'Alene, ID  
208-765-6351  
<http://www.cutsharper.com>

### DeHart Tooling

"The former DeHart Tooling assets need to be sold and represent a substantial amount of time, effort, as well as financial resources. With the passing of my father the business had to be closed and now the equipment and facility need to be sold in order to settle the estate."

Contact: Anthony DeHart  
[anthony\\_dehart@charter.net](mailto:anthony_dehart@charter.net)

## Western Oregon Saw shop

Small shop - run by Mom and Pop with one employee.

Currently in the garage but could easily be moved. They do have an industrial space but family illness requires a sale so they have no moved yet.

Shop is full of Wright Equipment in beautiful shape.

Customer base is long term, industrial customers.

Plenty of room for growth.

Call Carbide Processors at 800 346-8274 and we will put you in touch.

## 26th Annual WMI Workshop on Design, Operation and Maintenance of Saws and Knives

October 13-14, 2014  
**Holiday Inn Portland Airport**  
8439 NE Columbia Blvd, Portland,  
OR 97220  
Tel: 800-315-2621 or 503-256-5000  
direct

The material presented will benefit: Production Supervisors, QC Personnel, Saw and Knife Maintenance Personnel, Saw Filers and Saw Manufacturers who are seeking to optimize saw design. Also benefitting will be Safety Managers.

### For further information, contact:

Ryszard (Richard) Szymani, Saw Doctor  
Tel/Fax: 1-925-943-5240  
Cell: 1-925-360-4201

E-mail:  
[szymani@cwoodmachining.com](mailto:szymani@cwoodmachining.com)

## **Skinny Dippers**

Ron, an elderly man in Australia, had owned a large farm for several years. He had a large pond at the back. It was properly shaped for swimming, so he fixed it up nice with picnic tables, horseshoe courts, and some orange and lime trees.

One evening the old farmer decided to go down to the pond, as he had not been there for a while, and look it over. He grabbed a five-gallon bucket to bring back some fruit. As he neared the pond, he heard voices shouting and laughing with glee.

As he came closer, he saw it was a bunch of young women skinny-dipping in his pond. He made the women aware of his presence, and they all went to the deep end.

One of the women shouted to him, "We're not coming out until you leave!"

Ron frowned, "I didn't come down here to watch you ladies swim naked or make you get out of the pond naked".

Holding the bucket up Ron said, "I'm here to feed the alligator."

## **All I Want Is a Beer**

One Friday night, a 17-year-old boy went into a bar and sat down at a table in the corner of the poolroom. When the waitress walked over to his table, the teenager said: "Gimme a beer".

The waitress eyed him for a moment and said: "Look, sonny. Do you want to get me in trouble?"

The boy glanced back at her and replied: "Maybe later. Right now, all I want is a beer

## **The Sign**

A boss was complaining in a staff meeting the other day that he was not getting any respect. Later that morning he went to a local sign shop and bought a small sign that read, "I'm the Boss". He then taped it to his office door.

Later that day when he returned from lunch, he found that someone had taped a note to the sign that said. "Your wife called, she wants her sign back!"

## **Unusual Affair**

Paddy and his two friends are talking at a bar.

His first friend says, "I think my wife is having an affair with the electrician. The other day I came home and found wire cutters under our bed and they weren't mine."

His second friend says, "I think my wife is having an affair with the plumber the other day I found a wrench under the bed and it wasn't mine."

Paddy says, "I think my wife is having an affair with a horse." Both his friends look at him with utter disbelief.

"No, I'm serious," Paddy says. "The other day I came home and found a jockey under our bed."

## **Hark, I Hear the Cannons Roar**

An out-of-work actor gets a call from his agent one day. "I've got you a job," says his agent. "That's great," says the actor, "what is it?" "Well," says his agent, "it's a one-liner" "That's okay," replies the actor, "I've been out of work for so long I'll take anything. What's the line?" "Hark, I hear the cannons roar" says the agent. "I love it" says

the actor "When's the audition?" "Wednesday" says the agent.

Wednesday comes and the actor arrives at the audition. He marches on stage and shouts: "Hark, I hear the cannons roar". "Brilliant," says the director, "you've got the job. Be here 9 o'clock Saturday evening."

The actor is so happy he got the job that he goes on a major bender. He wakes up at 8:30 Saturday evening and runs to the theatre continually repeating his line; "Hark, I hear the cannons roar, hark, I hear the cannons roar, hark, I hear the cannons roar."

He arrives at the stage entrance, out of breath and is stopped by the guard. "Who the hell are you?" asks the guard. "I'm "hark, I hear the cannons roar". If you're "hark I hear the cannons roar", you're late. Get up to makeup right now!"

So he runs up to makeup. "Who the hell are you?" asks the makeup girl. "I'm "hark I hear the cannons roar." "If you're hark I hear the cannons roar", you are late. Sit down here." And she applies the makeup. "Now quick, get down to the stage, you're about to go on."

He dashes down to the stage. "Who the hell are you?" asks the stage manager. "I'm "hark, I hear the cannons roar". "You're "hark, I hear the cannons roar?" Get out there, the curtain's about to go up."

He tears onto the stage. The curtains rise, the house is full.

Suddenly there is an almighty bang behind him, and the actor shouts "WHAT THE HECK WAS THAT?"

## Quick Fire Drinks

Guy walks into a bar and says, "Quick, give me three shots of your finest whiskey!"

The bartender pours the shots and the man downs them as quickly as he can. Bartender says, "What was that about?"

Guy says, "You'd do the same if you had what I have."  
Bartender: "What's that?"  
Guy: "70 cents".

## The Pickle Slicer

Bill worked in a pickle factory. He had been employed there for many years when he came home one day to confess to his wife that he had a terrible compulsion. He had an urge to stick his penis into the pickle slicer.

His wife suggested that he should see a sex therapist to talk about it, but Bill said he would be too embarrassed. He vowed to overcome the compulsion on his own.

One day a few weeks later, Bill came home and his wife could see at once that something was seriously wrong.

"What's wrong, Bill?" she asked.

"Do you remember that I told you how I had this tremendous urge to put my penis into the pickle slicer?"

"Oh, Bill, you didn't!" she exclaimed.

"Yes, I did", he replied.

"My God, Bill, what happened?" she asked.

"I got fired," he replied.

"No, Bill. I mean, what happened with the pickle slicer?" she demanded.

"Oh... she got fired too."

## Gone Camping

Four friends spend weeks planning the perfect lake camping and riding trip.

Two days before the group is to leave, Rob's wife puts her foot down and tells him he is not going. Rob's friends are very upset that he cannot go, but what can they do.

Two days later the three get to the camping site only to find Rob sitting there with a tent set up, firewood gathered, and supper cooking on the fire.

"Dang man, how long you been here and how did you talk your wife into letting you go?"

"Well, I've been here since yesterday. Yesterday evening I was sitting in my chair and my wife came up behind me and put her hands over my eyes and said 'guess who'?"

I pulled her hands off and she was wearing a brand new see through nightie. She took my hand and took me to our bedroom. The room had two dozen candles and rose pedals all over. She had on the bed, handcuffs, and ropes! She told me to tie and cuff her to the bed and I did.

Then she said, "Now, you can do whatever you want."

So here I am.



## Come to the Filers' Meeting



### Learn to Solve Problems



### Bring Your Wife



### Friendly People



### Chance to Ask Questions



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

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## Inside

It has been a busy summer and we have not done a newsletter for a few months.

We got this one out to advertise the WSFEA September 12<sup>th</sup> meeting in Clackamas, Oregon.

There is not much of our advertising but there is a lot of good information on filers' meetings.

Yes we still have jokes in addition to the educational material.

## Next Issue

We talk about carbide. We have spent a couple years separating fact from fiction. We explain the difference between good carbide and cheap carbide.

**Want to Be Famous**  
**Sent us an article and we will run it**

## We Buy:



**Scrap Carbide – about \$8.10 for sawtips with braze alloy on them**  
Saw Tips - with or without braze alloy  
End mills, Solid carbide router bits  
Solid carbide anything

**We also buy Stellite®, Jonalloy® and similar**

**Maybe we can buy your grinding sludge** - call for details 800 346-8274

**We can buy high speed steel** but it is about \$1 / # so you need a lot to make it worthwhile.

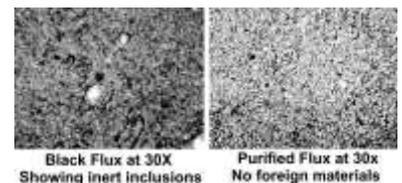
**800 346-8274**

## Business For Sale

Dehart Tooling  
[anthony\\_dehart@charter.net](mailto:anthony_dehart@charter.net)

This was a company that made beautiful tools and was run very well. Sale is due to death in the family, estate taxes, etc.

## Purified flux



**A little more money and a lot more performance**

**Want an email edition - just email**  
[sales@carbideprocessors.com](mailto:sales@carbideprocessors.com)

**10% Discount on great tools**  
[www.carbideprocessors.com](http://www.carbideprocessors.com)  
enter 'sawfiler10' at checkout