



# Carbide Processors, Inc.

Northwest Research Institute, Inc.

## Newsletter Holidays, 2014

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

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

## The Mark Riggs Free Beer with Hat Policy

I was caught in rush-hour traffic on the way to Oregon saw filer meeting. By the time I got there, I was thirsty and hungry so I went into the bar to get a glass of water and a sandwich.

There was Mark Riggs wearing one of our Carbide Processors hats with lights. I figured I should buy him a beer for all the advertising he was doing for us and he thought that was a good idea. He was sitting with a couple people so I bought them a beer as well.



So we now have a free beer with free hat policy. If we see you wearing one of our hats, we will buy you a free beer.

If Norm Brown is already buying beer, we will all drink on his tab.

The hats are free. Call 800-346-8274 or email [sales@carbideprocessors.com](mailto:sales@carbideprocessors.com). Pretty girl is not included.

## Frozen Wood

What we use on frozen hard maple is a fairly aggressive frost tooth and we run this year around because it seems to reduce washboard at high speeds and we do not have to have winter and summer saws. We take a diamond tool and place a notch in the grinding wheel to make our frost tooth.

Mike West  
Cascade Hardwoods

## New & Better Carbide Options

**You get many more carbide choices from Carbide Processors**

1. A much larger inventory of ready to ship carbide.
2. American made carbide by special order or pre-arrangement
3. Premium European carbide that is advertised as best in the world
4. Lower-cost Chinese carbide that is generally pretty good



Our lovely and charming carbide expert, Emily, has been working very hard with suppliers the past year.

**If you need:  
Better quality, delivery you can trust, a stocking program, lower prices, special grades odds are pretty good we can help you.**

## Really Good Filers

It seems like really good filers share at least two characteristics. 1. They keep digging down in their operation until they know what is really going on. 2. They are always eager to learn how to do things better

## Neal Davis Hammertime Saw

[hammertimesaw@gmail.com](mailto:hammertimesaw@gmail.com)

206-735-1285



Neil says he has done a bunch of training sessions in the last couple months. One was at vortex in Wisconsin.



**Neil was really impressed with the vortex crew which is hardly a surprise if you know how good Vortex is overall**

Could You Benefit From A Consultant?  
See article on page 4, please.

If you do consulting, please let us know and we will mention you.

## Vollmer Service

Burl Swiger - Triple S  
5347 N.E. Farmcrest St.  
Hillsboro, OR 97124  
triple-S@comcast.net  
Cell 503 803 6838

## Redding Show

California Western Saw filer  
Educational Association.

Mr. Krentz and Mr. Steed are both  
on the board for the Redding Show  
(June 26-27)

Email for either gentlemen  
richsteed@hotmail.com

Bob Krentz Cell 530-524-8668

## Warning

**Redding filer meeting  
Vendors register now**

There was one empty vendor table last  
year and it looks like this year's  
meeting is going to be even more  
popular. Carbide Processors is already  
registered its table. If you are a vendor  
who wants to exhibit, I suggest you  
register soon as you can. Call Paul  
Duclos 503-753-5302  
pduc3@AOL.com

## ISKA News

The Membership is now accessible  
online (the password is 1965) and  
we have banner ads for sale.

You can purchase a banner ad for  
\$200 for 12 months. We will limit it  
to 10 at one time. The ads need to  
be 911 x 100 in size.

Thanks. Let me know if you would  
like to participate. We appreciate  
your membership.

Tim Rief  
Tim Rief and Associates, Inc.  
26391 Crown Valley Parkway #230  
Mission Viejo, CA 92691  
949 480-1228  
866 751-4979 fax  
714 329-9843 mobile

**From Natalie Brillhart  
nbrillhart@sawsystemsinc.com**

Hi Tom, Thank you for the kind  
comments about Cheryl and me at the  
ISKA event in your Aug newsletter.  
Also, a BIG thank you for the great  
publicity for the organization. It is  
greatly appreciated. I visited your  
website and was surprised at the variety  
of products you offer. The site is very  
well organized. Hope to see you at the  
next event. Stay sharp, Natalie

Natalie Brillhart  
P: 800-966-1300  
F: 330-963-2985  
E: nbrillhart@sawsystemsinc.com

We are launching a newly updated  
website in the next few days.

### Upcoming ISKA Events:

March 20, 2015 ISKA Winter  
Meeting  
March 21, 2015 ISKA Fishing Trip  
Punta Gorda, Florida  
4 Points Sheraton Harborside  
[http://www.fourpointspuntagordahar  
borside.com/](http://www.fourpointspuntagordaharbor.com/)  
Special Rate of \$179/nt.

April 16 & 17, 2015  
Hammering Seminar  
Hickory, NC

### Free Advertising from ISKA

The organization needs your expertise!  
Please take this opportunity to write a  
short 2-3 paragraph article on your  
newest technology, discovery, or  
product. Your fellow members want to  
"keep sharp". So, do not pass up the  
FREE advertising in this new feature of  
the "CUTTING TIMES". Please email:  
nbrillhart@sawsystemsinc.com or fax  
1-330-963-2985 your questions and  
your information.

Natalie Brillhart  
Assistant Editor

## Rudi Sommer & Mike Halterman

Would you put this in your next  
issue Mike Halterman / Rudi  
Sommer are the corn hole  
champions at the Western Saw  
Filers Meeting two years in a row  
Thank You  
Brian Miller, Missoula Saws

Editor's Note: Rudi Sommer does a  
huge amount of unpaid work as  
vendor rep for the Western Saw  
Filers. It is fair to say that the  
meetings would not be nearly the  
success they are without Rudi's hard  
work. He is not paid for this so you  
really ought to call Missoula and  
buy something expensive to say  
"thank you".

## Old head Rig Wanted

Ganahl Lumber is looking for a 9' to  
10' head rig (Band Saw) to put in front  
of our new store. The brand we would  
like is a Sumpter Iron works or a Filer  
& Stols Band Saw.

These saws were built in Oregon at the  
turn of the century. Currently we have  
9 of them in front of our nine yards.  
We are looking for one more. Any  
information you could send me or any  
contacts would be very appreciated.



Here is a picture of our Anaheim yard  
saw in front of the store, this should  
help. If you need any more  
information, please call me.

Doug Christensen  
Planing Mill Manager  
Direct: 714 239-2135  
Fax: 714 239-2129  
Cell 714 936-8013  
[dougchristensen@GANAHL.com](mailto:dougchristensen@GANAHL.com)

# Super "C" Carbide Grade

Tougher than C1 - Better wear than C3

## What Makes Super C Tips Truly Superior

1. Superior Abrasion Resistance - Abrasion or straight wear is countered by smaller, better grain size.
- 2 & 3. Superior Adhesion and Diffusion Resistance (corrosion and chemical attack) Super C grade of carbide has an extremely fine structure so there is very little binder presented to the material being cut. This, combined with the special metallurgical formulation the Super C binder (hint - it's not just plain Cobalt) creates an extremely wear and corrosion material for use in wood, plastic or non-ferrous metals.
4. Superior Fatigue Resistance

**And People Really Like Them - Call Today To Try Them - Most Sizes Readily Available**

Super C	Hardness (HRA)	T.R.S. (psi)
	92.2 - 92.4	530,000 +

### Typical C2 values

	Hardness (HRA)	T.R.S. (psi)
C2	92.1	334,000
C2	91.8	334,000
C2	91.5	377,000
C2	90.4	435,000

### Typical C Values

	Hardness	T.R.S. (psi)
C1	89 - 92.4	350,000 - 360,000
C2	91.2 - 92.9	250,000 - 400,000
C3	91.4 - 93.6	270,000 - 350,000
C4	89.6 - 93	260,000 - 450,000

### Sawmill Grade Tips

- Transverse rupture strength well above 500,000 psi.
- Rockwell A hardness above 92
- Alloy binder for corrosion resistance
- Grain structure to inhibit both crack initiation and crack propagation
- Micro grain or mixed grain for superior wear

**Carbide Processors, Inc.  
800 346-8274**

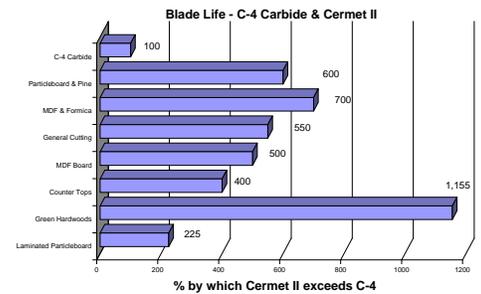


## Cermet II® 8 days instead of 5 in MDF

**Three weeks and three full loads of double side melamine laminate instead of 1 week and 1 load with carbide**

1. 5 blades with standard C-4 carbide cutting 45 lb. single and double sided vinyl-laminated particle board  
\* Cermet II - 15,088 meters / old grade - 6706 meters **225% as much run life**
2. KM-16 industrial saw cutting 101.6 mm x 152.4 mm (4" x 6") Green hardwoods, oak, hickory, maple and walnut using 11 blades with standard C-4 carbide  
\* Cermet II / 462 hrs / old grade - 40 hrs **1,155% as much run life**
3. 406 mm (16") 100 teeth cutting countertops  
\* Cermet II - 4 weeks / old grade - 1 week (4 times) **400% as much run life**
4. 406 mm (16") 80 teeth cutting MDF Board  
\* Cermet II - 10 days / old grade - 2 days (5 times) **500% as much run life**
5. 305 mm (12") 100 teeth TCG Miter cutting oak, Compressed Fiber Board, Plastic  
\* Cermet II - 154 hrs / old grade - 28 hrs (5.5 times) **550% as much run life**
6. 305 mm (12") 60 teeth cutting MDF, High Pressure Laminate (Formica)  
\* Cermet II - 56 hrs / old grade - 8 hrs (7 times) **700% as much run life**
7. G 1060A on Chop Saw cutting Particle Board and Pine Dowel Rods  
\* Cermet II - 48 hrs / old grade - 8 hrs (6 times) **600% as much run life**

**Use Cermet 2 instead of carbide and make your life much easier**



## Cermet II® Successes

Several times the life in a window and door plant.

3 times the life in Corian.

8 days instead of 5 in MDF and we have an even better grade coming.

Twice the life in beetle killed Lodge Pole pine.

### Benefits You Get

- \* Grinds like regular carbide
- \* Gives a better edge than carbide
- \* Stays sharper longer than carbide
- \* Great increase in fracture toughness.
- \* More corrosion-resistant
- \* Better at high temperatures
- \* Cuts faster
- \* Cuts faster & longer yet is tougher
- \* Longer runs and less downtime.

## Report from Marvin Windows

On the saw that we tried. How many times we sharpen a blade before we order new or have retipped we are not sure. Most blades get damaged by hitting something so we have the carbides retipped a lot. How often do regular blades have to be sharpened? We normally have our carbide tipped blades sharpened every week.

The new Cement II blade normally last twice as long before it gets damaged. The best so far is four weeks and one and a half million cuts before we changed it out which is four times longer.

Hope this helps and keep up the good work on those tips.

Nathan Hull, Grinderman

Marvin Wood Products

## Saw Filer Jobs

Swanson Group is in need of a journeyman saw filer.

Contact:

Karen Holt, SPHR

Human Resource Manager

Swanson Group Mfg.

2695 Glendale Valley Rd.

P.O. Box 250

Glendale, OR 97442

Office: (541) 832-1272

Fax: (541) 832-1408

Cell : (541) 621.0486

Karen.holt@swansongroup.biz

### Hampton Lumber Mills- Warrenton

OR Division is currently looking for a qualified Sawfiler, primarily band saws with at least a working knowledge of round saws. Guides, machine center line up, and knife changes. Candidates must have the ability to learn and willingness to work in a team environment. Safety first attitude is a must.

We have Clean filing rooms, great work environment and great benefits.

Compensation depends on experience, but could be up to \$25.10 plus shift differential. Send resumes to: jimbenett@hamptonaffiliates.com.

Paula Huston

HR Manager- Tillamook Division

Hampton Lumber Mills

503-815-6303 office

503-866-7394 cell

### Band Saw Person

Live on the beautiful Oregon coast,

Pay: \$25.10 + shift dif

Shift: probably swing

Benefits: 401k, medical insurance,

paid holidays, excellent working

environment. Call for more details

Mark Lencioni

Saw Filing Supervisor

Cell 503-962-9476

Office 503-861-5356

marklencioni@hamptonaffiliates.com

m

## Could You Benefit From A Consultant?

Neal Davis called the other day and we got talking about consulting jobs he was doing.

Sometimes there is no one in the filing room who knows how to hammer. Some filing rooms even have stretcher rolls sitting in a corner because no one knows how to use them and they need a little repair work.

A more common reason is bringing somebody in from outside to train new employees.

The problem with new employees is that you have to train them before you can get any work out of them. We figure that one new employee with one experienced employee training them does about half to three quarters of the work that he experienced employee would do on their own. In addition, the experienced employee is always a really good employee because we want new people trained by the best.

In a great number of filing rooms, head filer could certainly do a lot of training if they did not have to do their job as well as covering the work the new people should be doing.

The sooner you can get new people trained so that they are productive the better for everybody.

In many cases they head filer is good and, besides getting new people trained, appreciates the chance to compare techniques with another experienced filer.

## Wanted: Guide Milling Machine

I am looking for a used Thompson bandsaw guide milling machine with the capability to mill a square guide and a bevel guide. Some of the older ones may still have a R Hoe sticker on them.

Dick Bernier, Filing Supervisor

Columbia Vista Corp  
dbernier@columbiavista.com  
360-892-0770 x123 office  
360-640-1148 mobile

## Goodman Saw has used Equipment for Sale

[goodmansaw@uswest.net](mailto:goodmansaw@uswest.net)

Among other items is:

Armstrong 310-c

A 30 round saw stretcher roll

Tall acme post grinder

Wright 1700 profiler.

Roundsaw and bandsaw anvils.

We are no longer servicing large roundsaws keeping more to our bandsaw retipping and trim/edger saw business. I can be contacted at [goodmansaw@uswest.net](mailto:goodmansaw@uswest.net) with all the specs pictures and prices  
Regards Rick Goodman

## New HMT website

Brian Haas / HMT Machine Tools, Inc.  
[bhaas@hmtmachinery.com](mailto:bhaas@hmtmachinery.com)

As a fellow ISKA member, HMT Machine Tools, Inc. would like to reach out to you regarding big changes in our company. Please visit our new website for a full listing of our services.

On the products side, HMT Machine Tools, Inc. offers new machines from Gerling Automation and Loroch, filtering and coolant chiller systems through Elite, and HMT Certified Pre-Owned machines from many manufacturers.

We offer complete rebuilds for Gerling, Loroch, Vollmer, Schmidt-Tempo, Akemat, and Wagner. All of our certified rebuilds come with a warranty. We also offer parts, onsite machinery repairs, and telephone support to our clients.

131 Elliana Way, Ste. D, Summerville, SC, 29483  
Phone: 843-832-4410  
Fax: 843-832-4475  
Web: [HMTmachinery.com](http://HMTmachinery.com)  
Email: [BHaas@hmtmachinery.com](mailto:BHaas@hmtmachinery.com)

## Purified Flux

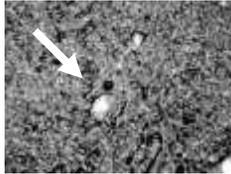
30% To 100% Better  
Braze Joints  
(50x magnification)



Purified flux  
Smooth &  
consistent



Standard flux  
Large grains of  
foreign material



**You can see and feel the difference immediately.**

Purified flux is black flux that has had extra processing steps. These processing steps take the black article out and leave the flux a rich, creamy brown color. If you take a little of each flux and rub it between your fingers you can feel that Purified Flux is not only smoother but the particles are smaller and there are no extra large particles.

Flux is made to prevent oxygen from getting to the parts as they are heated. Steel and especially tungsten carbide oxidize at room temperature. The hotter they get the more they oxidize. Above 1,000 F tungsten carbide oxidizes extremely rapidly and forms an unbrazable surface. Purified flux is good for more time at higher temperatures, up to 1,700 F.

The original idea with flux was that it was to be applied on top of the braze area. However the critical part of saw and tool brazing is what goes on inside the braze joint. Ordinary flux is inexpensively made and has up to 10% odd size particles and non-active minerals in it. These odd size particles and non-active minerals get lodged in the braze area and can seriously effect the strength of the braze joint.

**Purified flux is cleaner, smoother, creamier and much more effective.**

5 # jars

Case (6 jars @ 5#) \$ 464.31

Single jar \$ 87.39

## Braze Alloys (Silver Solders)

The right braze alloy can make a huge difference in performance

Braze Alloy Impact & Bond Strength Tests	
<b>High Impact</b>	<b>100%</b>
S50N - 50% Silver with Cadmium	100%
A50N - 50% Silver - Cadmium free	75%
A56T - 56% Silver with Tin	0%
S50N - 50% Silver with Cadmium	100%
A50N - 50% Silver - Cadmium free	64%
A50N with copper spheres added	67%

### Stop tip Loss - Prevent Carbide Breakage

Saw tips are brazed onto a steel saw using braze alloy. When a tungsten carbide saw tip breaks it is usually bad carbide, the wrong grade of carbide, the wrong braze alloy or a combination of these.

The brazing process forms a three part composite. The success of the composite depends on the tungsten carbide, the steel, the braze alloy and the way it is all put together. The braze alloy has to do three things. 1. It has to keep the tip on the saw. 2. It has to cushion the tip because the tip suffers a lot of impact stress when the saw cuts. 3. It has to compensate for the difference in expansion between steel and tungsten carbide as they are heated and cooled during brazing.

## Buy Our Books

Buy online or call 800 346-8274

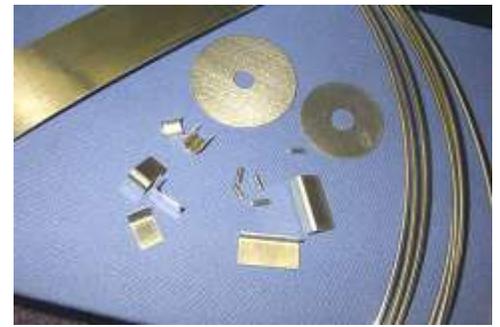
1. Carbide Saw Specification Manual  
<http://www.cafepress.com/sawspecs.80466877>

2. Carbide Saw Manual - Lowell freeborn  
<http://www.cafepress.com/freebornmanual.80464996>

3. Managing Coolants from Machining and Grinding Operations  
<http://www.cafepress.com/managecoolants.80458178>

4. Building Superior Brazed Tools  
<http://www.cafepress.com/superiortools.93943435>

5. Braze Failure Analysis  
<http://www.cafepress.com/brazefailure.79434854>



We sell braze alloys (also called silver solders, high temperature silver solders, or braze filler metals.)

We supply the finest information in the world on the selection and use of braze alloys for carbide brazing.



### The Finest, Most Consistent Braze Alloys For Tungsten Carbide

- 26 Different braze Alloys
- All AWS approved
- All inspected to parts per million
- All alloys exceed AWS specifications
- Cadmium free
- With Cadmium
- Hi Impact – developed for Weyerhaeuser
- Ultra Hi Strength – High Temp.
- Low Silver – Very High Strength
- Low Temp. with high strength
- Wire – all diameters
- Ribbon - all sizes
- Sandwich alloy ribbon
- Brazing preforms

### Why Quality Makes A Difference

(American Welding Society AWS 5.8) Braze alloy can be within AWS specifications but it can vary in brazing temperature by as much as twenty degrees. This means that you can have cold joints and tip one end or zinc loss and more broken tungsten carbide tips at the other end.

Our braze alloy is accurate and measured within parts per million. It is typically four times better than it has to be or more according to government certified analysis. It brazes the same way every time.

## **Small Price Increase on Filters**

For years, Carbide Processors has worked hard to bring you very reasonable prices on quality products. We do everything we can to bring you great values and stretch your dollars. However, due to the increase in our costs, we must raise the price on our 5-micron Filter Cartridges to \$19.50.

We have avoided raising our prices on the filter replacement Cartridges for as long as possible, but we can no longer prolong the inevitable.

We thank you for your loyalty and understanding for the necessity of this price increase.

For any inquiries, suggestions, and concerns regarding the increase, or our services, do not hesitate to call our toll free number at 800-346-8274.

Thank you for your continuing patronage and support.

Sincerely,  
Emily George  
Carbide Processors, Inc.  
3847 South Union Avenue Tacoma,  
WA 98409  
Phone: 253-476-1338 Fax: 253-476-1321 sales@carbideprocessors.com

## **Minnesota bank robbery**

A hooded robber burst into a Minnesota bank and forced the tellers to load a Sack full of cash.

On his way out the door, a brave Minnesota customer grabbed the hood and pulled it off, revealing the robber's face. The robber shot the customer without a moment's hesitation.

He then looked around the bank and noticed one of the tellers looking straight at him. The robber instantly shot him also.

Everyone in the bank, by now very scared, looked intently down at the floor in silence.

The robber yelled, "Well, did anyone else see my face?"

There are a few moments of utter silence in which everyone was plainly too afraid to speak.

Then, one old Norwegian named Ole' from Minnesota tentatively raised his hand and said, "My wife got a pretty good look at you."

## **Matt Harris Steps UP**

Matt Harris of Oleson / Yok donated \$78 for prizes for the saw filer fishing derby. Oleson / York is getting quite a reputation on the West Coast for selling saws that arrive on time and work well. They also have a bandsaw bench that is drawing a lot of interest.

## **Williams & White & Great Machines**

I am really impressed with the quality and design of their new machines. Big, solid, easy to service machines. Very well designed.

Williams & White Group of Companies  
6307 Laurel Street, Burnaby, British Columbia, Canada V5B 3B3  
+1.604.293.2268 |  
[sales@williamsandwhite.com](mailto:sales@williamsandwhite.com)

## **Vollmer**

Vollmer has reduced costs in some of their grinders by having part of the work done in china. The critical parts are manufactured in Germany and shipped to China. The Chinese do the castings, sheet metal and finish building the units. The finished units are shipped to Germany for final inspection.

Vollmer is selling machines faster than they can install them according to Mike Cubbon.

## **Wright Machines**

No new machines from Wright as far as I know. However, I am hearing good things about the support and service from Wright. The whole Burton / Wright organization has always impressed me as an outfit that just does things very well.

## **Vollmer Service from Triple S**

Burl Swigart, Retired Filer, and Owner Triple S; is staying more than busy doing Vollmer repairs and rebuilds. Burl is not a Vollmer employee. He is an ex filer with decades of experience running, selling, servicing and repairing Vollmers.

Last time I talked to Burl, he had just repaired a Vollmer that had a bearing in backwards. I learned two things. Machines run better if the bearings are in correctly. If you put a bearing in wrong and then run the machine for a while, it can be a real near of a task to remove that bearing.

## **Neal Davis, Hammertime.**

We have heard a few reviews about Neal and his hammering classes. The reviews are all very good. Many filers can hammer. Neal can both hammer and teach hammering, which are two different things. Even if you can hammer and teach hammering, how often do you have a full day to go one - on - one in a training session?  
Neal Davis 206-735-1285

## **You Can Be a Star**

We think the industry needs more, good filer-to-filer training material and we are willing to pay for it. If you have an idea for a video, let us know and we will pay up to \$1,000 for the filming and editing. You do the writing and performing.

We want videos showing how you do it in real life. For more info, call Tom 800 346-8274  
president@carbideprocessors.com

## A New Carbide Program

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

There is 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 usually 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 our but we are starting to supply new grades and less expensive tips. Call for more info..

## Did Noah Fish?

A Sunday school teacher asked, "Johnny, do you think Noah did a lot of fishing when he was on the Ark?" "No", replied Johnny. How could he, with just two worms?"

## Scrap

We are currently paying \$7.00 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 \$5.90 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 1-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](http://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)

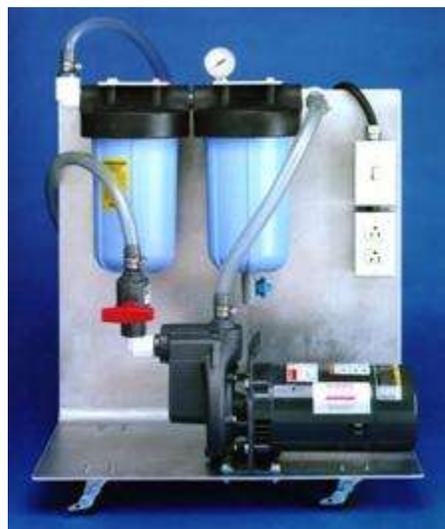
One bacteria / fungus test, five pH strips and one 250 ml cylinder plus shipping no charge.

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

## Filtering Straight Oil / Water Based Coolants



We now have a filter system that filters straight oil coolants. Above is our CP 2020 which filters tight oil coolant very well. It is also available as a wall mount unit.



Here is our CP 2002, which has been an extremely good unit on water based coolants for about eight years.

We have tried it on straight oil with very poor results. It filtered for maybe an hour before it plugged up.

Oil is much thicker than water. The filters were good enough to filter the oil for awhile but, as soon as they started to load up with dirt, the oil was too thick to get through.



Here are the two units side by side.

A filter is a series of holes that separates particles from liquid. Oil is thicker than water so it is harder to filter out small particles. In addition oil transfers the pressure from the pump directly to the filter and is much more likely to collapse a filter element.

The secret is a high-tech filter. This is stainless steel inside and outside to handle the pressure. It is smaller than our water filters and has a pleated surface to provide sensational filter surface area at the high pressures oil creates.



We recommend monthly filter changes but many go much longer than that.

## Great Filter Units

For Straight oil, Synthetic and Water - based coolants.

**Really popular – We're selling a bunch of them**



Great prices, pay for themselves readily, cleaner shops, less labor and longer diamond wheel life with better, faster grinds.

**Now accepting Visa & MasterCard**

Call Us at 800 346-8274 or Equipment Ltd at 800-533-2006

### Coolant filter Life

We recommend a filter change after one month in use on a single machine which is about 160 hours of use. In our tests we have seen them go 21 days of 20 hour shifts, which is 420 hours. Many folks get 2 or 3 months out of the filters which is 320 to 480 machine hours.

The rating is based on the amount of sludge generated by the machine in an hour. If you run a machine 40 hours and filter one hour then you remove all the sludge from the 40 hours of running.

If you are running 11 machines then you are getting 440 hours life out of the filters in a week.

Two things can happen. 1. If filters are run too long they can load up and releases over and over so they don't do any good past a certain point. It looks like they are working, however. This is like pouring fifty gallons of water in a five gallon bucket. It works because when you are through the 50 gallon drum is empty and the bucket is full. You just ignore the water on the ground. 2. After a long enough time there will be a lot of sub-micron particles in the coolant and this can give it a gray color.

# 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 pick ups 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 (Might Already Be Sold)

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.**

## Ear Infection

This is so true! They always ask at the doctor's office why you are there, and you have to answer in front of others what is wrong and sometimes it is embarrassing.

There is nothing worse than a Doctor's Receptionist who insists you tell her what is wrong with you in a room full of other patients.

I know most of us have experienced this, and I love the way this old sawfiler handled it.

A 65-year-old man walked into a crowded waiting room and approached the desk.

The Receptionist said, 'Yes sir, what are you seeing the Doctor for today?'

'There's something wrong with my dick', he replied.

The receptionist became irritated and said, 'You shouldn't come into a

crowded waiting room and say things like that. '

'Why not, you asked me what was wrong and I told you,' he said.

The Receptionist replied; 'Now you've caused some embarrassment in this room full of people. You should have said there is something wrong with your ear or something and discussed the problem further with the Doctor in private.'

The man replied, 'You shouldn't ask people questions in a roomful of strangers, if the answer could embarrass anyone. The old sawfiler walked out, waited several minutes, and then re-entered.

The Receptionist smiled smugly and asked, 'Yes?'

'There's something wrong with my ear,' he stated.

The Receptionist nodded approvingly and smiled, knowing he had taken her advice. “And what is wrong with your ear, Sir?”

'I can't piss out of it,' he replied.

The waiting room erupted in laughter...

## Men

A few moments after the daughter announced her engagement, her Father asked, "Does this fellow have any money?"

The daughter shook her head sadly. "Oh Daddy! You men are all alike." Sighing deeply, she replied, “That's exactly what he asked me about you.”

## Good Samaritan

A Sunday school teacher was telling her class the story of the Good Samaritan. She asked the class, "If you saw a person lying on the roadside, wounded, and bleeding, what would you do?" A thoughtful little girl broke the hushed silence; I think I'd throw up..."

## Unanswered Prayer

The preacher's 5 year-old daughter noticed that her father always paused and bowed his head for a moment before starting his sermon. One day, she asked him why.

"Well, Honey", he began, proud that his daughter was so observant of his messages. "I'm asking the Lord to help me preach a good sermon."

"How come He doesn't answer it?" she asked.

## Being Thankful

A Rabbi said to a precocious six-year-old boy, "So your mother says your prayers for you each night? That is very commendable. What does she say?" The little boy replied, "Thank God he's in bed!"

## Elephant

A young man was on holiday in Kenya after graduating from college. While he was walking through the bush, he came across a young bull elephant standing with one leg raised in the air.

The elephant seemed distressed so the man approached it very carefully. He got down on one knee and inspected the elephant's foot. There was a large thorn deeply embedded in the bottom of the foot.

As carefully and as gently as he could he worked the thorn out with his hunting knife, after which the

elephant gingerly put down its foot. The elephant turned to face the man and with a rather stern look on its face, stared at him. For a good ten minutes the man stood frozen -- thinking of nothing else but being trampled.

Eventually the elephant trumpeted loudly, turned, and walked away.

The man never forgot that elephant or the events of that day.

Twenty years later the man was walking through the zoo with his teen-aged son. As they approached the elephant enclosure, one of the creatures turned and walked over to where they were standing at the rail. The large bull elephant stared at him and lifted its front foot off the ground then put it down. The elephant did that several times, all the while staring at the man. The man could not help wondering if this was the same elephant.

After a while, it trumpeted loudly; then it continued to stare at him.

The man summoned up his courage, climbed over the railing, and made his way into the enclosure. He walked right up to the elephant and stared back in wonder.

Suddenly the elephant trumpeted again, wrapped its trunk around one of the man's legs and swung him wildly back and forth along the railing, killing him. Probably was not the same elephant.

## Bus Stop

Two men are sitting at a bus stop on a dusty out of the way road. Both are dressed in business suits and are your typical white male, except one has a giant orange head. The normal man turns to the other and asks, "So, what's with the giant orange head?"

The other replies, "Well, it wasn't long ago I was walking down a dusty road similar to this one here when I came upon an old oil can laying in the ditch. Well I picked it up and rubbed it and, as one might expect, a genie appeared offering me three wishes.

"I thought for a long time, having never seriously considered the question, but finally I told him, 'for my first wish I ask for enough wealth to live comfortably the rest of my years'. The genie nodded and said, 'it is done,' and there before me were massive piles of money next to a mansion.

"Fairly impressed, I sat down and began to think about my next wish. This one took me a lot longer, because with all this wealth what more could I ask for? Finally, it came to me in a flash of insight.

"Genie, for my second wish I wish for a beautiful wife with whom to spend this wealth.' He nodded once more and said, 'it is done.' I turned and she was there. I loved her instantly and she returned that love.

"I thought much longer on my third wish, because I wanted to be absolutely sure that I got it right. I had already used two wishes and was incredibly happy with them, but the third needed to be perfect. But to answer your original question, here is where I think I went wrong, because I wished for a giant orange head."

## Texting

A middle-aged couple had finally learned how to send and receive texts on their cell phones.

The wife, being a romantic at heart, decided one day that she would send her husband a text while she was out

of the house having coffee with a friend.

She texted: If you are sleeping, send me your dreams.

If you are laughing, send me your smile.

If you are eating, send me a bite.

If you are drinking, send me a sip.

If you are crying, send me your tears.

I love you.

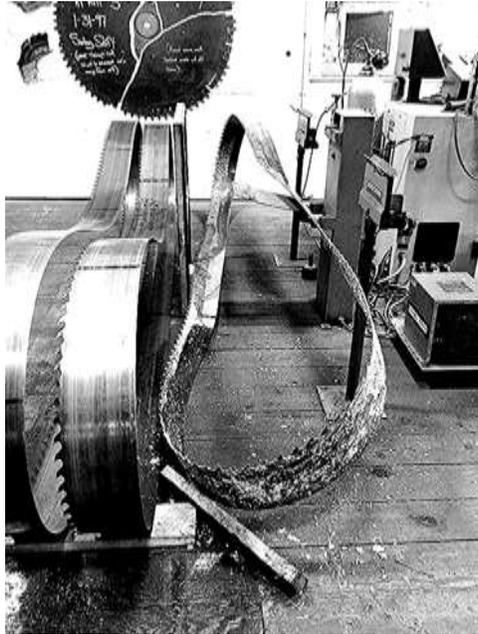
The husband, being a no-nonsense sort of guy, texted back: I am on the toilet. Please advise.

(Brings a tear to the eye, doesn't it?)

**Mr. Harley (of Harley-Davidson fame)** died & while he was waiting at the Pearly Gates for processing St. Peter said to him, "Hey — you're a famous guy, would you like to hang out with God for a while?" "Sure", said Mr. Harley. After their meeting God said, "I'm glad you are here. I wanted to talk to you about your invention". God started to rag on Mr. Harley about all the troubles associated with the Harley-Davidson motorcycle. When God was finished, Mr. Harley asked about one of God's inventions. God said "which one?" Mr. Harley said, "The women". God said, "What's wrong with it". Mr. Harley started ragging all about the problems associated with the women. When he was finished God went over to His celestial computer, punched in a few numbers and out popped a report. God looked the report over and said, "according to this report, more men ride my invention than yours".

Greg P. Toberman  
Atascadero Saw & Sharpening  
Proprietor  
8981 La Linia Ave Unit L  
Atascadero, CA. 93422  
805-466-5220

## Bandsaws from Jedd Ebner



## The Best Carbide

You deserve carbide that works.

That is what we thought when we got started in 1981 and we still believe it.

In the last couple of years, the whole carbide situation has gotten more and more complicated. There seems to be a race to the bottom pricewise. This has led some suppliers to sell

anything that looks like a saw tip as long as it is cheap enough.

The problem with trying to cheat in the carbide industry is that eventually the customer is going to cut something with it. If it does not work, the customer is going to know it.

For the past six months, we have been intensively studying the carbide industry and various carbide suppliers.

First, we had to determine what quality was. Dr. Deming says that quality is exactly what the customer says it is. That has always made sense to us so we talked to customers.

The first thing our customers wanted was carbide that made their customers happy. They wanted carbide that would stay in the saw. They wanted carbide that would cut without breaking. They wanted carbide that would be good service life on a consistent basis.

The second thing the customers wanted was carbide that worked in their shop. They wanted an accurate count so that they got everything they paid for. They wanted every piece in the box to be usable. They wanted very consistent sizing so that the parts all fed well in automated systems. They wanted parts that brazed well and ground the same way every time.

Finally, they wanted parts when they needed them. Especially they expected parts when they were promised.

The biggest complaint overall was about suppliers who couldn't be trusted

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

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## Happy Holidays

With the changes in the Post office we are not sure when you will get this. However, Happy Holidays anyway.

We are not sending out special cards this year. Again, we are donating that money to the Salvation Army for baby food.

## Next Month

One of Mike West's Saw Filer group discussions on band saw wheels.

## Free advertising here for

Educational activities  
Saw Filer Groups  
ISKA  
Wood Machining Institute

## Want to Be Famous

Sent us an article and we will run it  
We will also pay for the production of an educational video

## We Buy:



**Scrap Carbide – about \$7.00 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**

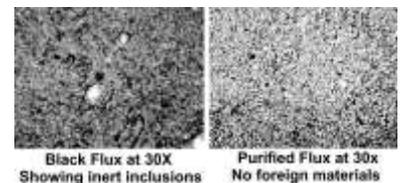
**Maybe we can buy your grinding sludge - call for details 800 346-8274**

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

**800 346-8274**

**Inside  
Businesses For Sale  
Equipment for sale  
Equipment Wanted  
Jobs for saw filers**

## Purified flux



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