



President's Message

## A Real Gentleman (Sawfiler Style)

We got a call from Buddy Gibson of Gibson Saw. We like Buddy because he is a nice guy and does a really good job. Anyway we were talking and I told Buddy I would go get a Tempil Stik and send it to him. Buddy said he could get it himself. I told him I appreciated his business and would be happy to do it for him. Then I asked him if he was sure that he wasn't being too polite. Without a moment's hesitation Buddy replied "Oh, Heck No!" which proves he is a real gentleman (sawfiler style).

**It's not the big that beats the small  
It's the fast that beats the slow**



### Why I Don't Travel

First, I don't get invited many places and I hate just to barge in on folks. Mostly, though, it is health reasons. I have one of those funny, genetic diseases that leaves me weak and tired. The new doctor has me to the point where I can work full days most days, which is a blessing. It is just hard to travel.

# Carbide Processors, Inc.

Northwest Research Institute, Inc.

Newsletter February, 2009

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

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



## The Sawfiler Rules On Steel

Sawfiler® brand saw plate comes in more kinds and sizes than any other brand.

**1. Secret Japanese Steel, my sweet Aunt Fannie.** We have two grades of steel for long plate life. Both are better than the "secret, special, Japanese" steel.

**2. Saw Plate - Standard**  
We proudly sell Peerless saw plate as our standard plate. Peerless offers saw plate that is very flat. It has a high nickel content which makes it tougher especially in severe side loading. The quality is very high and very consistent. The technical information available from Peerless is unequalled and their customer service is excellent.

**3. Saw Plate - Super Flat**  
These are from a smaller plate company that specializes in high performance steel that is super flat. They produce plate that does not require further smithing. This plate is typically only a few dollars more than Peerless.

**4. Saw Plate - Economy Plate**  
Typically about 20 to 25% less than Peerless. T 42 - 44 Rc and easier to stress relieve and to flatten.

### Get the most Tip for your money

Cermet II tips last 10 times longer than carbide  
Cut smoother and reduce plate hammering.

Carbide Processors, Inc.  
800-346-8274  
sales@carbideprocessors.com  
www.carbideprocessors.com

#### Average Run Time



3847 South Union Avenue Tacoma, WA 98409-4621

## Saw Tips We have Saw Tips

**1. CERMET 2®**  
Incredibly long wear, tough as C-4 or maybe C-3 and as easy to braze and grind as carbide.

**2. SUPER C®**  
Longer wearing than carbide and as tough or tougher than C-1.



**3. Ten Cent Saw Tips**  
10,000 of these beauties. All sorts of shapes and sizes. If you can use them we have a real deal for you.

## We Buy Old Saw Tip Inventory

We buy old saw tips for about a nickel each if we think we can ever sell them. This is a better price than scrap.

**We are starting to buy carbide scrap again - It is off and on. Call Emily 800 346-8274.**

## Texas Stud

The Texan wished to become a "stud" in Houston.

His final thoughts were, "Its sure going to get boring standing here holding this sheet rock."

## Mike West Explains auto air conditioning

The four Goldberg brothers, Lowell, Norman, Hiram, and Max, invented and developed the first automobile air-conditioner. On July 17, 1946, the temperature in Detroit was 97 degrees.

The four brothers walked into old man Henry Ford's office and sweet-talked his secretary into telling him that four gentlemen were there with the most exciting innovation in the auto industry since the electric starter.

Henry was curious and invited them into his office. They refused and asked that he come out to their car in the parking lot

They persuaded him to get into the car, which was about 130 degrees, turned on the air conditioner, and cooled the car off immediately.

The old man got very excited and invited them back to the office, where he offered them \$3 million for the patent.

The brothers refused, saying they would settle for \$2 million, but they wanted the recognition by having a label, 'The Goldberg Air- Conditioner,' on the dashboard of each car.

Now old man Ford was more than just a little anti-Semitic, and there was no way he was going to put the Goldberg's name on two million Fords.

They haggled back and forth for about two hours, and finally agreed on \$4 million and that just their first names would be shown.

And so to this day, all Ford air conditioners show Lo, Norm, Hi, and Max on the controls.

So, now you know the rest of the story.....

## The Blonde & Storm Windows

The blonde tells her Story.

Last year I replaced all the windows in my house with that expensive double-pane energy efficient kind, and today, I got a call from the contractor who installed them. He was complaining that the work had been completed a whole year ago and I still hadn't paid for them.

Helloooo, just because I'm blonde doesn't mean that I am automatically stupid. So, I told him just what his fast talking sales guy had told me last year, that in ONE YEAR these windows would pay for themselves!

Hellooooo? It's been a year, I told him. There was only silence at the other end of the line, so I finally just hung up. He never called back. I bet he felt dumb.

## The Pope flies to NYC for a visit.

The Pope flies to NYC for a visit. His plane is late. He only has a few minutes to get from JFK to lower Manhattan for an appearance, and it's rush hour!

The Pope gets into a cab, tells the driver where he needs to go, and how soon he needs to be there. The driver replies that there is no way he can make it.

The Pope says "Let me drive!" The driver jumps in back, and the cab speeds away in spirited Euro-style driving! They don't even get off airport property before a cop pulls them over. The cop walks up to the car, looks inside, tells the occupants to wait, and goes back to his cruiser.

After seeing who is in the cab, the cop calls HQ and asks for his supervisor...

Cop: "I just pulled over a cab with a VIP, and I don't know if I should ticket them..."

Sarge: "How important? The Mayor?"

Cop: "more important..."

Sarge: "A movie star?"

Cop: "more!"

Sarge: "WHO did you pull over?"

Cop: "I don't know who he is, but he's got the Pope as a driver!"

## The Blonde Wife and Parking

One winter morning, a husband and wife in northern Michigan were listening to the radio during breakfast. They heard the announcer say, "We are going to have 8 to 10 inches of snow today. You must park your car on the even-numbered side of the street so the snowplows can get through."

So the good wife went out and moved her car.

A week later while they are eating breakfast again, the radio announcer said, "We are expecting 10 to 12 inches of snow today. You must park your car on the odd-numbered side of the street so the snowplows can get through."

The good wife went out and moved her car again.

The next week they are again having breakfast when the radio announcer says, "We are expecting 12 to 14 inches of snow today. You must park...."

Then the electric power went out.

The good wife was very upset and with a worried look on her face she said, "Honey, I don't know what to do. Which side of the street do I need to park on so the snowplows can get through?"

With the love and understanding in his voice that all men who are married to blondes exhibit, the husband replied, "Why don't you just leave it in the garage this time."



**From John Schultz**

You gotta love this guys explanation of hell...

The following is an actual question given on a University of Washington chemistry mid-term. The answer by one student was so "profound" that the professor shared it with colleagues, via the Internet, which is, of course, why we now have the pleasure of enjoying it as well:

**Bonus Question:** Is Hell exothermic (gives off heat) or endothermic (absorbs heat)?

Most of the students wrote proofs of their beliefs using Boyle's Law (gas cools when it expands and heats when it is compressed) or some variant. One student, however, wrote the following:

First, we need to know how the mass of Hell is changing in time. So we need to know the rate at which souls are moving into Hell and the rate at which they are leaving. I think that we can safely assume that once a soul gets to Hell, it will not leave. Therefore, no souls are leaving. As for how many souls are entering Hell, let's look at the different religions that exist in the world today. Most of these religions state that if you are not a member of their religion, you will go to Hell. Since there is more than one of these religions and since people do not belong to more than one religion, we can project that all souls go to Hell. With birth and death rates as they are, we can expect the number of souls in Hell to increase exponentially. Now, we look at the rate of change of the volume in Hell because Boyle's Law states that in order for the temperature and pressure in Hell to stay the same, the volume of Hell has to expand proportionately as souls are added.

This gives two possibilities:

1. If Hell is expanding at a slower rate than the rate at which souls enter Hell, then the temperature and pressure in Hell will increase until all Hell breaks loose.

2. If Hell is expanding at a rate faster than the increase of souls in Hell, then the temperature and pressure will drop until Hell freezes over. So which is it? If we accept the postulate given to me by Teresa during my Freshman year that, "It will be a cold day in Hell before I sleep with you," and take into account the fact that I slept with her last night, then number two must be true, and thus I am sure that Hell is exothermic and has already frozen over. The corollary of this theory is that since Hell has frozen over, it follows that it is not accepting any more souls and is therefore, extinct.....leaving only Heaven, thereby proving the existence of a divine being which explains why, last night, Teresa kept shouting "Oh my God."

THIS STUDENT  
RECEIVED THE ONLY "A."

**From Mike West**

Shit! I remember too many of these things, most of which were gone completely by the time I was in Junior High School. Crap, I don't even think they have "Junior High Schools" any more.

'Someone asked the other day, 'What was your favorite fast food when you were growing up?' 'We didn't have fast food when I was growing up,' I informed him. All the food was slow.'

'C'mon, seriously. Where did you eat?' 'It was a place called 'at home,'" I explained. ! 'Mom cooked every day and when Dad got home from work, we sat down together at the dining room table, and if I didn't like what she put on my plate I was allowed to sit there until I did like it.'

By this time, the kid was laughing so hard I was afraid he was going to suffer serious internal damage, so I didn't tell him the part about how I had to have permission to leave the table.

But here are some other things I would have told him about my childhood if I figured his system could have handled it.

Some parents NEVER owned their own house, wore Levis , set foot on a golf course, traveled out of the country or had a credit card.

In their later years they had something called a revolving charge card. The card was good only at Sears Roebuck. Or maybe it was Sears & Roebuck. Either way, there is no Roebuck anymore. Maybe he died.

My parents never drove me to soccer practice. This was mostly because we never had heard of soccer. I had a bicycle that weighed probably 50 pounds, and only had one speed, (slow).

We didn't have a television in our house until I was 19. It was, of course, black and white, and the station went off the air at midnight, after playing the national anthem and a poem about God; it came back on the air at about 6 a.m. and there was usually a locally produced news and farm show on, featuring local people.

I was 21 before I tasted my first pizza, it was called 'pizza pie.' When I bit into it, I burned the roof of my mouth and the cheese slid off, swung down, plastered itself against my chin and burned that, too. It's still the best pizza I ever had.

I never had a telephone in my room. The only phone in the house was in the living room and it was on a party line. Before you could dial, you had to listen and make sure some people you didn't know weren't already using the line.

Pizzas were not delivered to our home. But milk was. All newspapers were delivered by boys and all boys delivered newspapers --my brother delivered a newspaper, six days a week. It cost 7 cents a paper, of which he got to keep 2 cents. He had to get up at 6AM every morning.

On Saturday, he had to collect the 42 cents from his customers. His favorite customers were the ones who gave him 50 cents and told him to keep the change. His least favorite customers

were the ones who seemed to never be home on collection day.

Movie stars kissed with their mouths shut. At least, they did in the movies. There were no movie ratings because all movies were responsibly produced for everyone to enjoy viewing, without profanity or violence or most anything offensive.

If you grew up in a generation before there was fast food, you may want to share some of these memories with your children or grandchildren. Just don't blame me if they bust a gut laughing.

#### **How many do you remember?**

Head lights dimmer switches on the floor.

Ignition switches on the dashboard.

Heaters mounted on the inside of the fire wall.

Real ice boxes.

Pant leg clips for bicycles without chain guards.

Soldering irons you heat on a gas burner.

Using hand signals for cars without turn signals.

#### **Older Than Dirt Quiz :**

Ratings at the bottom.

1. Blackjack chewing gum

2. Wax Coke-shaped bottles with colored sugar water

3. Candy cigarettes

4. Soda pop machines that dispensed glass bottles

5. Coffee shops or diners with tableside juke boxes

6. Home milk delivery in glass bottles with cardboard stoppers

7. Party lines on the telephone

8. Newsreels before the movie

9. P.F. Flyers

10. Butch wax

11. TV test patterns that came on at night after the last show and were there until TV shows started again in the morning. (there were only 3 channels [if you were fortunate])

12. Peashooters

13. Howdy Doody

14. 45 RPM records

15. S& H greenstamps

16. Hi-fi's

17. Metal ice trays with lever

18. Mimeograph paper

19. Blue flashbulb

20. Packards

21. Roller skate keys

22. Cork popguns

23. Drive-ins

24. Studebakers

25. Wash tub wringers

0-5 = You're still young

6-10 = You are getting older

11-15 = Don't tell your age,

16-25 = You're older than dirt!

## **Why You Should Buy From Us**

### **We make your life easier**

Our products work- First time, every time.

If you have trouble using our products we have incredible tech support.

A. We have excellent written material.

B. We are always happy to solve problems on the phone at (800) 34608274.

C. We have an online video and excellent online material at [www.carbideprocessors.com](http://www.carbideprocessors.com).

D. We do the second best analysis in the industry. Zane Lockhart at Multi Metals is the best but he is heavy on materials. We are better on brazing.

### **We do free analysis**

## **100% no argument guarantee**

### **Do You Want an Edger Saw or an Expensive Edger Saw?**

This is Cliff's question. Lately a lot of folks are sure that they want a good edger saw that does the job but they don't want to spend anymore than they have to. Cliff has saved folks some pretty good money several ways.

**Call him at (800) 707-5802**

**Cell (503) 580 -3253**

## **Leonard Valadez**

Due to the weather and hazardous road conditions in December, a spring memorial service for Lennie has been scheduled for Saturday, March 28. I don't have everyone's email addresses so please pass this invitation on to anyone you know who may like to attend.

Graveside service 1:00

New Tacoma Cemeteries & Funeral

Home 9212 Chambers Creek Road

WestUniversity Place, WA

98467253 564-1311 Celebration

1:30-5:00Titlow Lodge Community

Center 8425 6th AvenueTacoma,

WA 98466



# Great Service on Grinder Parts

Cliff Gordon, from Carbide Processors, went out to repair a Grinder. Cliff decided to get the parts from Burl Swiger because that



was the best price for the customer. It turned out to be one of those jobs, like most of them, where things looked a little different once you got the machine open. There were parts needed that hadn't been anticipated.

Burl did an incredible job. He was right there with answers, knew what the parts were and got them right away. All at good prices.

The customer was really happy. Cliff was so happy that he bought Burl lunch besides giving him several thousand dollars for the parts.

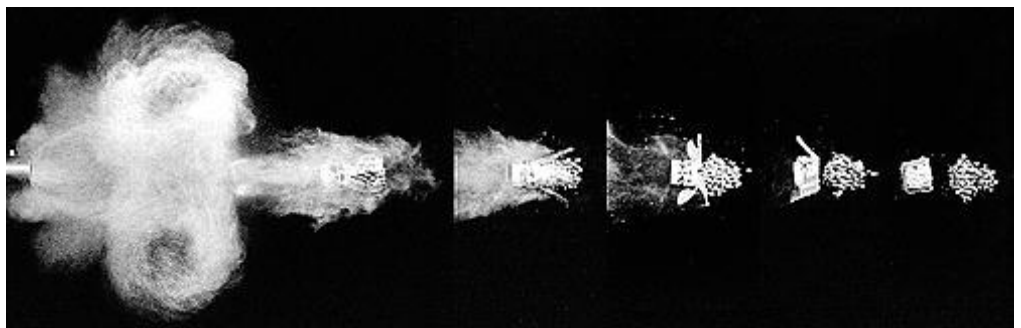
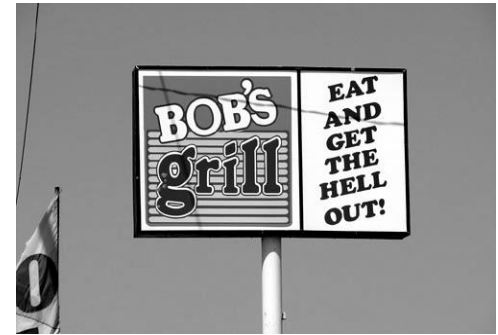
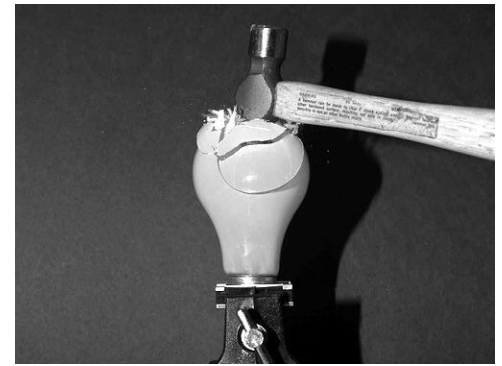
I don't suppose even Burl can work miracles every time but it wouldn't hurt to call him for parts and rebuilt equipment.

Burl Swiger - Triple S  
Cell: 503 803-6838  
Home: 503 648-6297  
Email [triple-s@comcast.net](mailto:triple-s@comcast.net)

Grinder parts and service  
Loaner programs for: Cast spindle housings, infeed, spindles, CSA?XL@ and Truesizer parts and Service  
Accu-Lube parts and service, Heavy Duty Weld circuit for Model 85 tipper

### Questions on grinders and grinder repair call:

Cliff Gordon (800) 707-5802  
Cell (503) 580 -3253  
Fax 503 838-0490  
[cliffjanisg@hotmail.com](mailto:cliffjanisg@hotmail.com)



- **Cut Costs**
- **Do Less Work**
- **Run Longer With Fewer Saw Changes**
- **Do Fewer Retips**

## 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

## Cermet II®

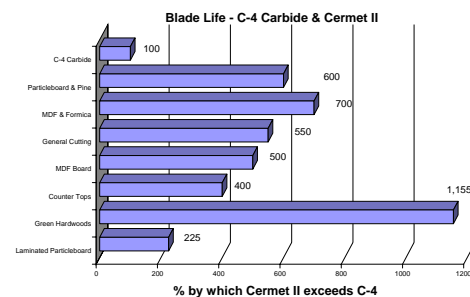
8 days instead of 5 in MDF

**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 for **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**

## 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

## Filtering 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.

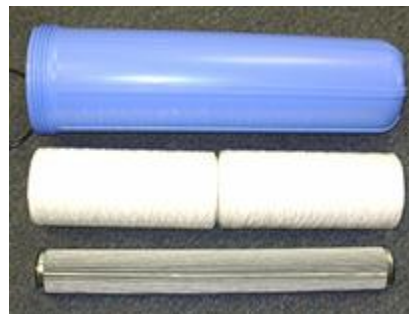
Oil is much thicker than water. The filters were good enough to filter the oil for awhile but, as soon as they started to a load up with dirt, the oil was too thick to get through.



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 though 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.

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

## **Saw Tips \$0.10**

30,000 carbide tips more or less - about 100 sizes

We bought an old IKS inventory, sorted it out, cleaned it up, labeled it and now we want to turn it into cash. Different sizes and grades. Many are already pretinned.

If we were really bright we would sell these at full price as people ordered them but times are tight and you want low prices. Besides cash is better than old inventory.

## **We buy old tips**

We pay about a nickel a piece for old saw tips depending on what they are.

## **Save Money, Big Money on Saw Plate**

Three grades of saw plate P. 1

## **Get First Chance at Sales**

Just ask us to add you to our email sales list. Email Emily at [sales@carbideprocessors.com](mailto:sales@carbideprocessors.com). Our \$0.10 tip sale is popular and we seem to get more in all the time. If you want an early look at the list ask for an email. If you don't like email, call 800 346-8274 and asks for a faxed list.

## **We can Pretin Untreated Carbide**

We have our own, in-house treatments.



**Above is our pictorial report on the economy**